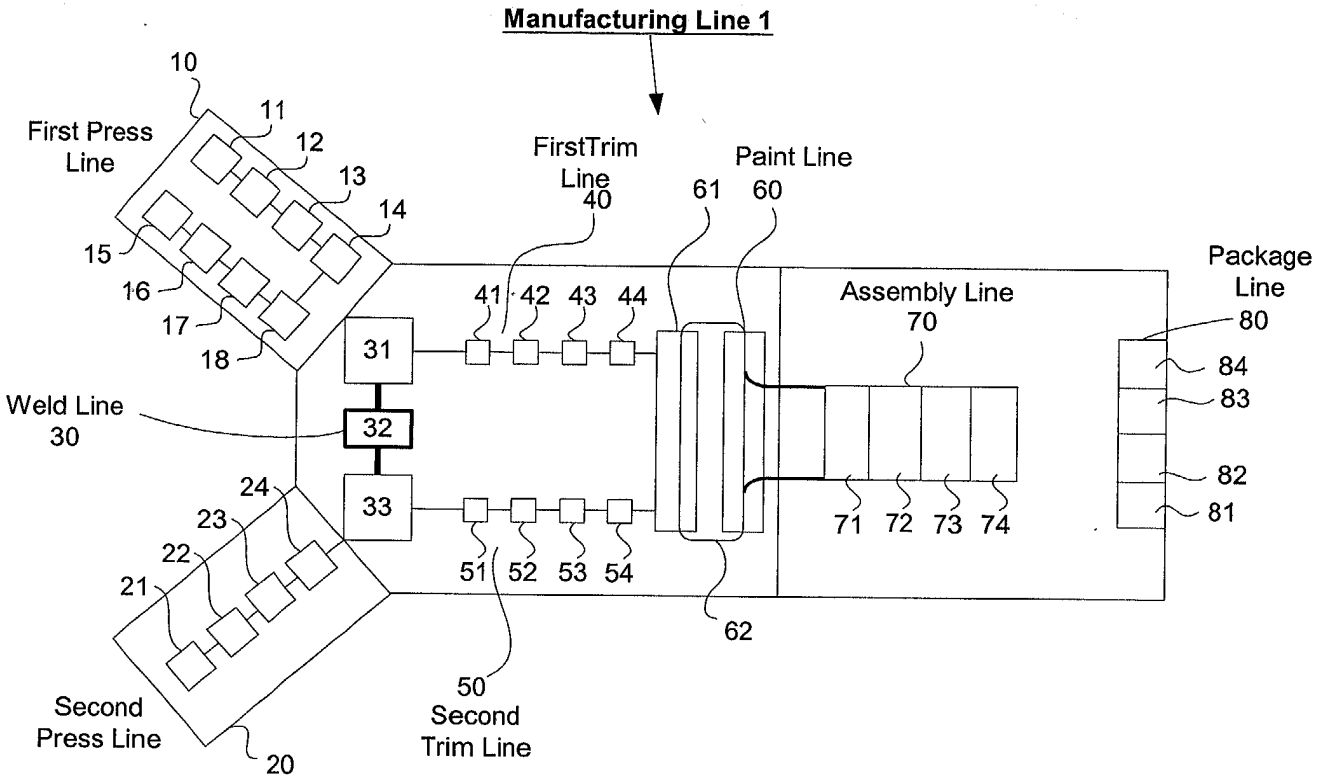

Manufacturing Line 1
First Press Line
FirstTrim Line
Paint Line
Assembly Line
Package Line
Weld Line
Second Press Line
Second Trim Line
10
11
12
13
14
15
16
17
18
20
21
22
23
24
31
32
33
40
41
42
43
44
50
51
52
53
54
60
61
62
70
71
72
73
74
80
81
82
83
84

Fig. 1

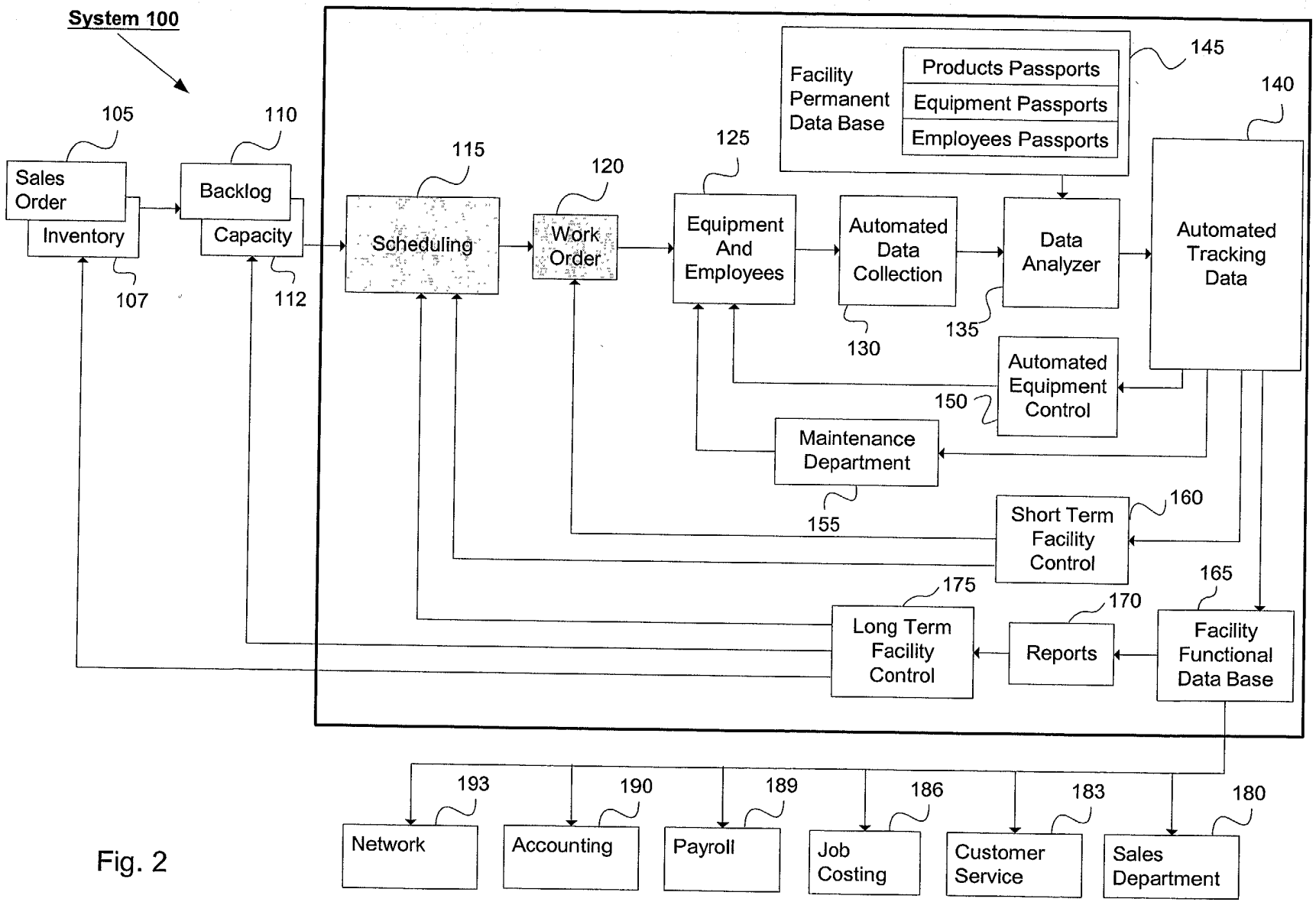

System 100
105
Sales Order
Inventory
107
110
Backlog
Capacity
112
115
Scheduling
120
Work Order
125
Equipment And Employees
Facility Permanent Data Base
Products Passports
Equipment Passports
Employees Passports
145
140
Automated Data Collection
130
Data Analyzer
135
Automated Tracking Data
Automated Equipment Control
150
Maintenance Department
155
Short Term Facility Control
160
165
Long Term Facility Control
175
Reports
170
Facility Functional Data Base
193
Network
190
Accounting
189
Payroll
186
Job Costing
183
Customer Service
180
Sales Department

Fig. 2

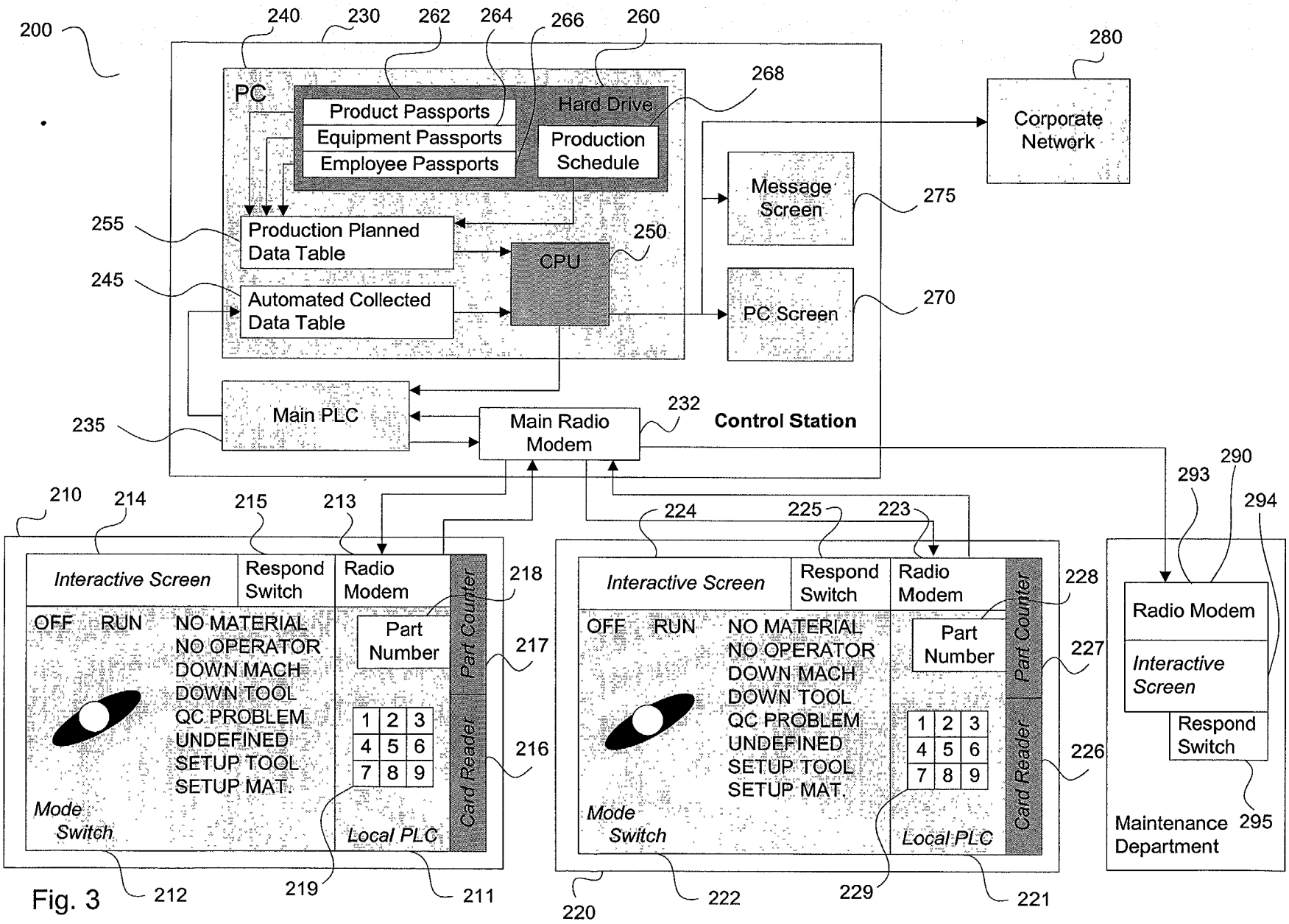

200
240
230
262
264
266
260
280
PC
Product Passports
Equipment Passports
Employee Passports
Hard Drive
Production Schedule
268
Corporate Network
Message Screen
275
255
Production Planned Data Table
250
CPU
245
Automated Collected Data Table
PC Screen
270
Main PLC
235
Main Radio Modem
232
Control Station
210
214
215
213
224
225
223
290
293
294
Interactive Screen
Respond Switch
Radio Modem
218
228
OFF
RUN
NO MATERIAL
NO OPERATOR
DOWN MACH
DOWN TOOL
QC PROBLEM
UNDEFINED
SETUP TOOL
SETUP MAT.
Part Number
217
227
1 2 3
4 5 6
7 8 9
Part Counter
Card Reader
216
226
Mode Switch
Local PLC
Radio Modem
Interactive Screen
Respond Switch
Maintenance Department
295
212
219
211
220
222
229
221

Fig. 3

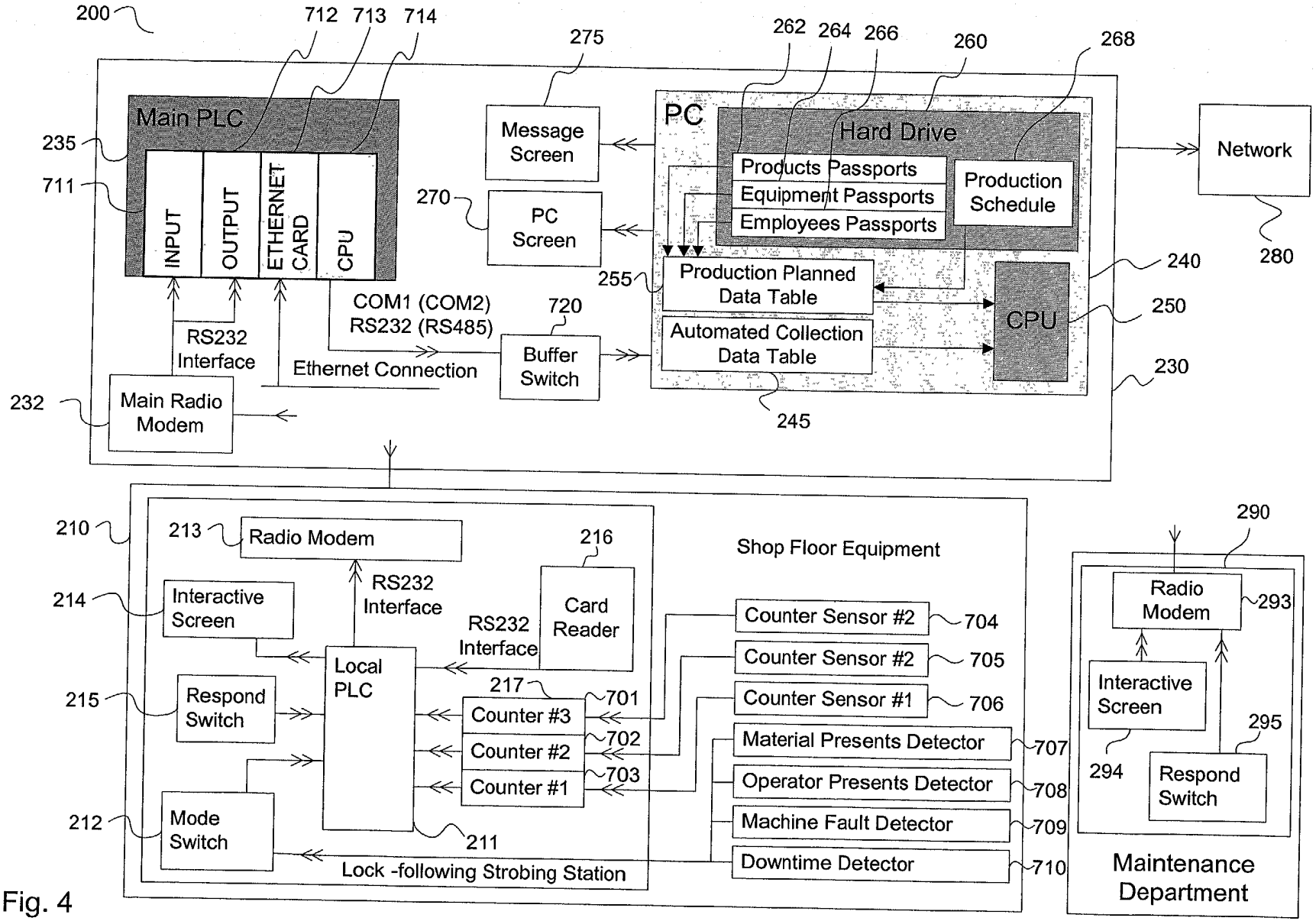

200
712
713
714
275
262
264
266
260
268
Main PLC
235
711
INPUT
OUTPUT
ETHERNET CARD
CPU
Message Screen
PC
Hard Drive
Products Passports
Equipment Passports
Employees Passports
Production Schedule
Network
280
270
PC Screen
255
Production Planned Data Table
240
CPU
250
COM1 (COM2)
RS232 (RS485)
720
RS232 Interface
Ethernet Connection
Buffer Switch
Automated Collection Data Table
230
232
Main Radio Modem
245
210
213
Radio Modem
216
Shop Floor Equipment
214
Interactive Screen
RS232 Interface
RS232 Interface
Card Reader
Counter Sensor #2
704
Counter Sensor #2
705
Counter Sensor #1
706
Local PLC
217
215
Respond Switch
Counter #3
701
Counter #2
702
Counter #1
703
Material Presents Detector
707
Operator Presents Detector
708
Machine Fault Detector
709
Downtime Detector
710
212
Mode Switch
211
Lock -following Strobing Station
290
Radio Modem
293
Interactive Screen
295
294
Respond Switch
Maintenance Department

Fig. 4

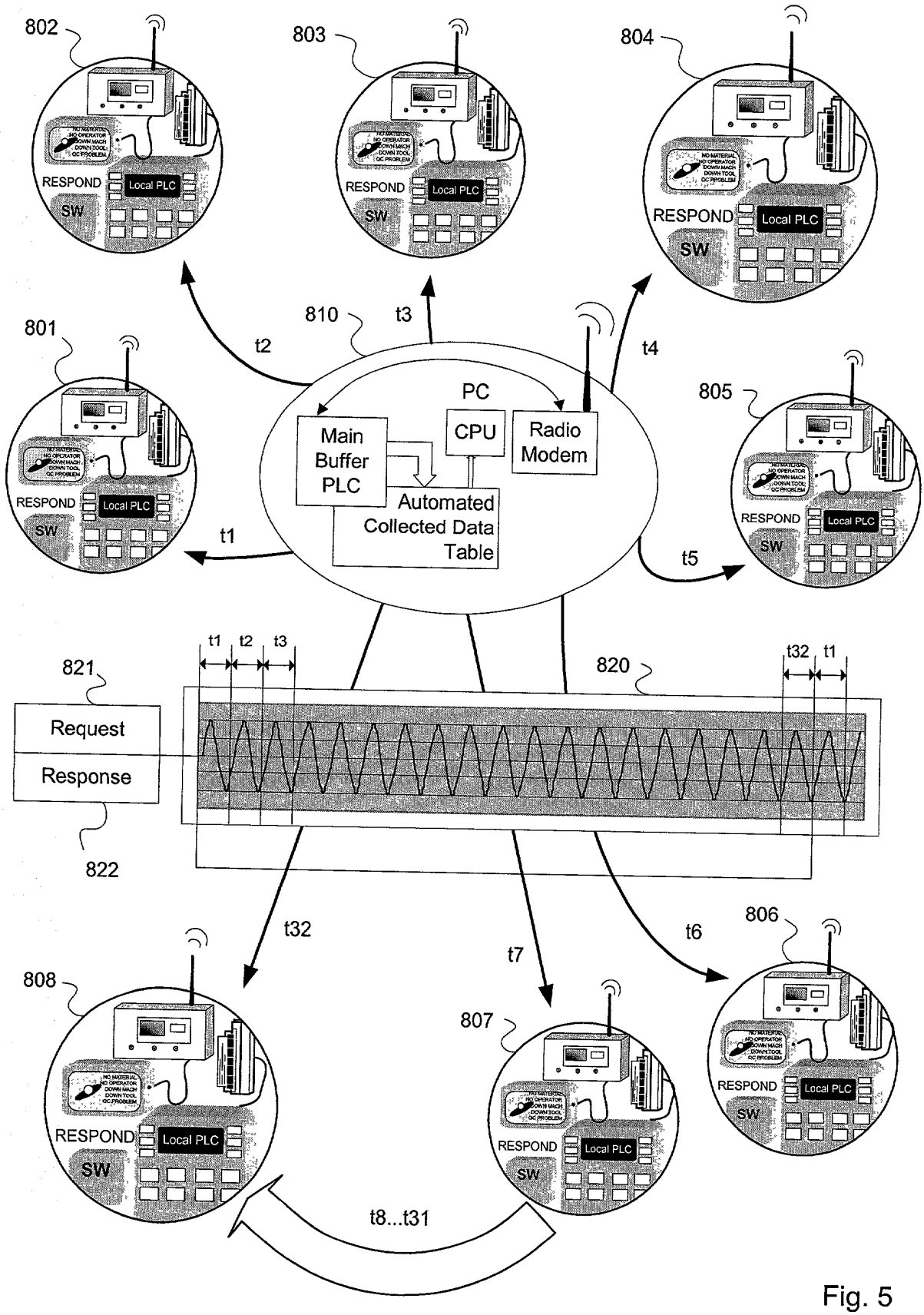

802
803
804
801
805
806
807
808
RESPOND
Local PLC
SW
810
t1
t2
t3
t4
t5
t6
t7
t8...t31
t32
PC
CPU
Radio Modem
Main Buffer PLC
Automated Collected Data Table
821
Request
Response
822
820
t1
t2
t3
t32
t1

Fig. 5

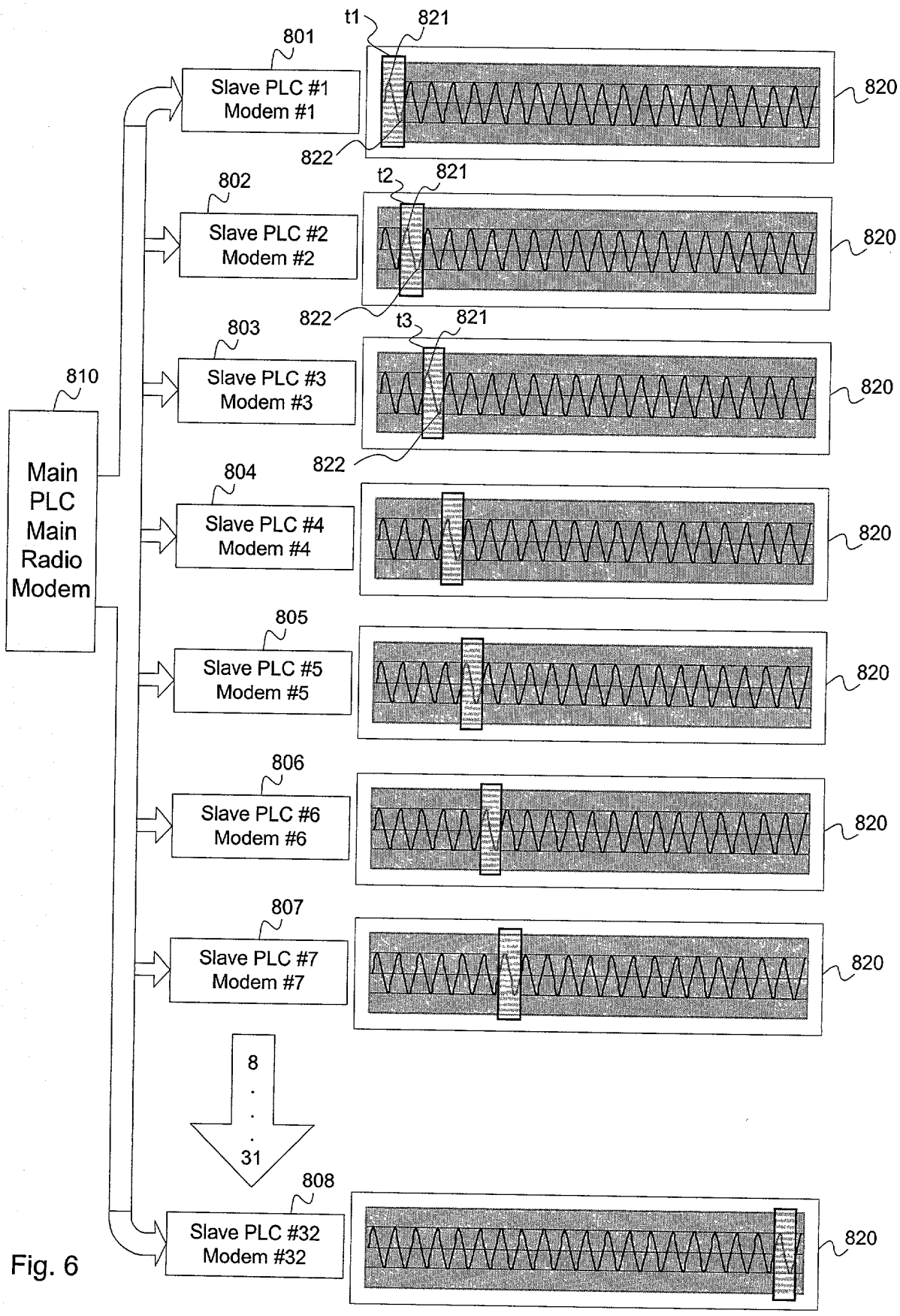

Main PLC Main Radio Modem
810
Slave PLC #1 Modem #1
801
Slave PLC #2 Modem #2
802
Slave PLC #3 Modem #3
803
Slave PLC #4 Modem #4
804
Slave PLC #5 Modem #5
805
Slave PLC #6 Modem #6
806
Slave PLC #7 Modem #7
807
8
31
Slave PLC #32 Modem #32
808
t1
t2
t3
821
822
820

Fig. 6

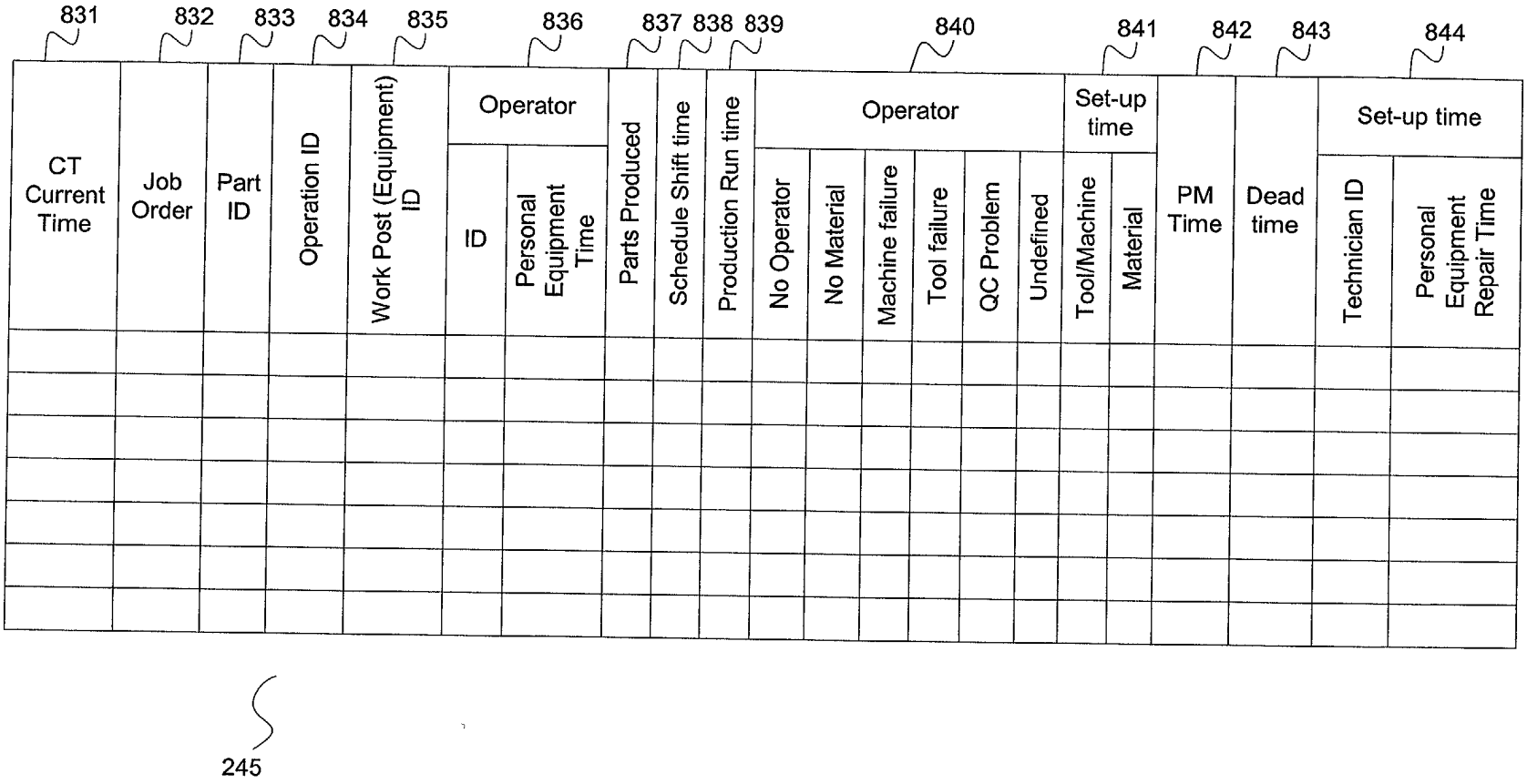

831
832
833
834
835
836
837
838
839
840
841
842
843
844
CT Current Time
Job Order
Part ID
Operation ID
Work Post (Equipment) ID
Operator
ID
Personal Equipment Time
Parts Produced
Schedule Shift time
Production Run time
Operator
No Operator
No Material
Machine failure
Tool failure
QC Problem
Undefined
Set-up time
Tool/Machine
Material
PM Time
Dead time
Set-up time
Technician ID
Personal Equipment Repair Time
245

Fig. 7

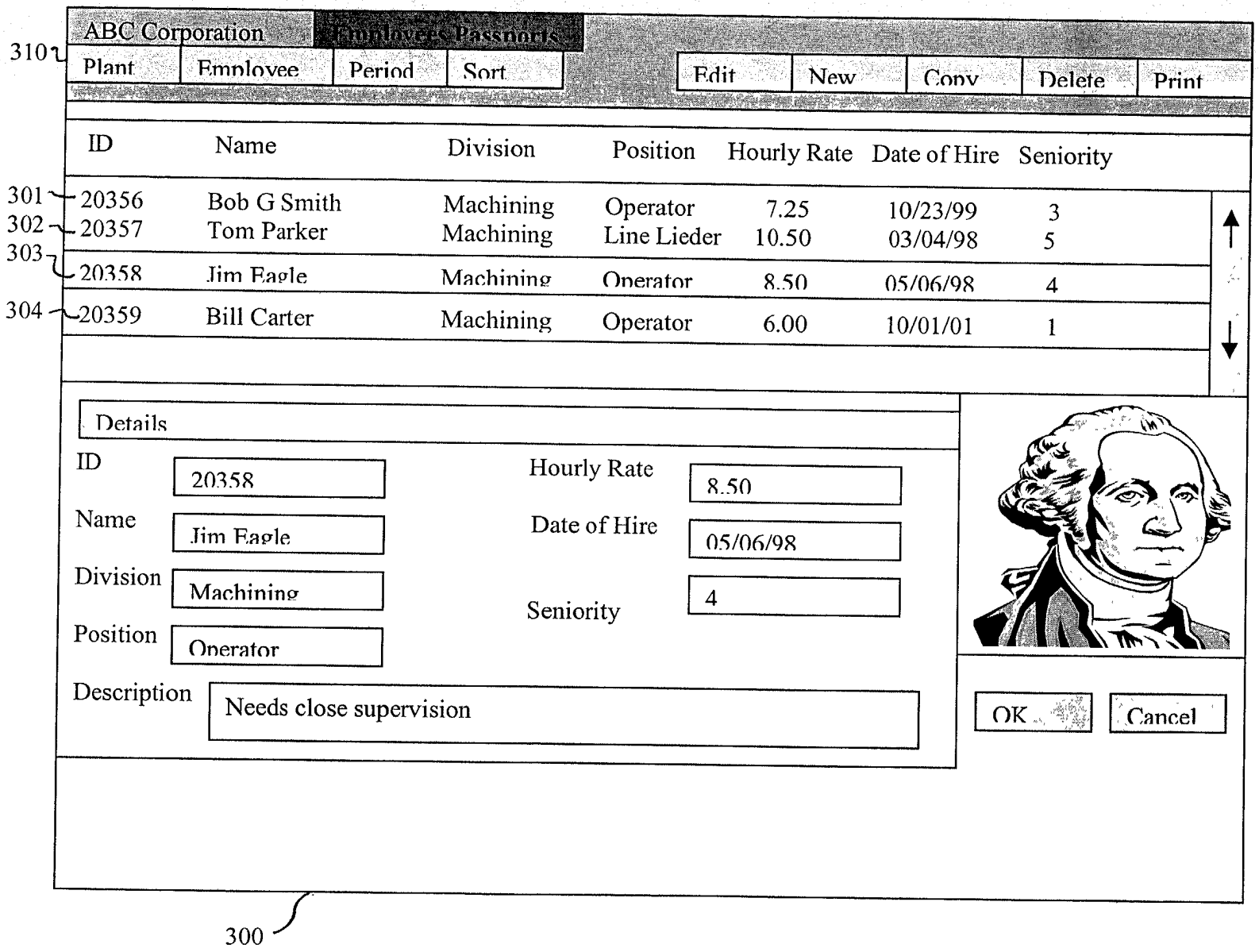

ABC Corporation
Employees Passports
310
Plant
Employee
Period
Sort
Edit
New
Copy
Delete
Print
ID
Name
Division
Position
Hourly Rate
Date of Hire
Seniority
301
20356
Bob G Smith
Machining
Operator
7.25
10/23/99
3
302
20357
Tom Parker
Machining
Line Lieder
10.50
03/04/98
5
303
20358
Jim Eagle
Machining
Operator
8.50
05/06/98
4
304
20359
Bill Carter
Machining
Operator
6.00
10/01/01
1
Details
ID
20358
Name
Jim Eagle
Division
Machining
Position
Operator
Hourly Rate
8.50
Date of Hire
05/06/98
Seniority
4
Description
Needs close supervision
OK
Cancel
300

Fig. 8

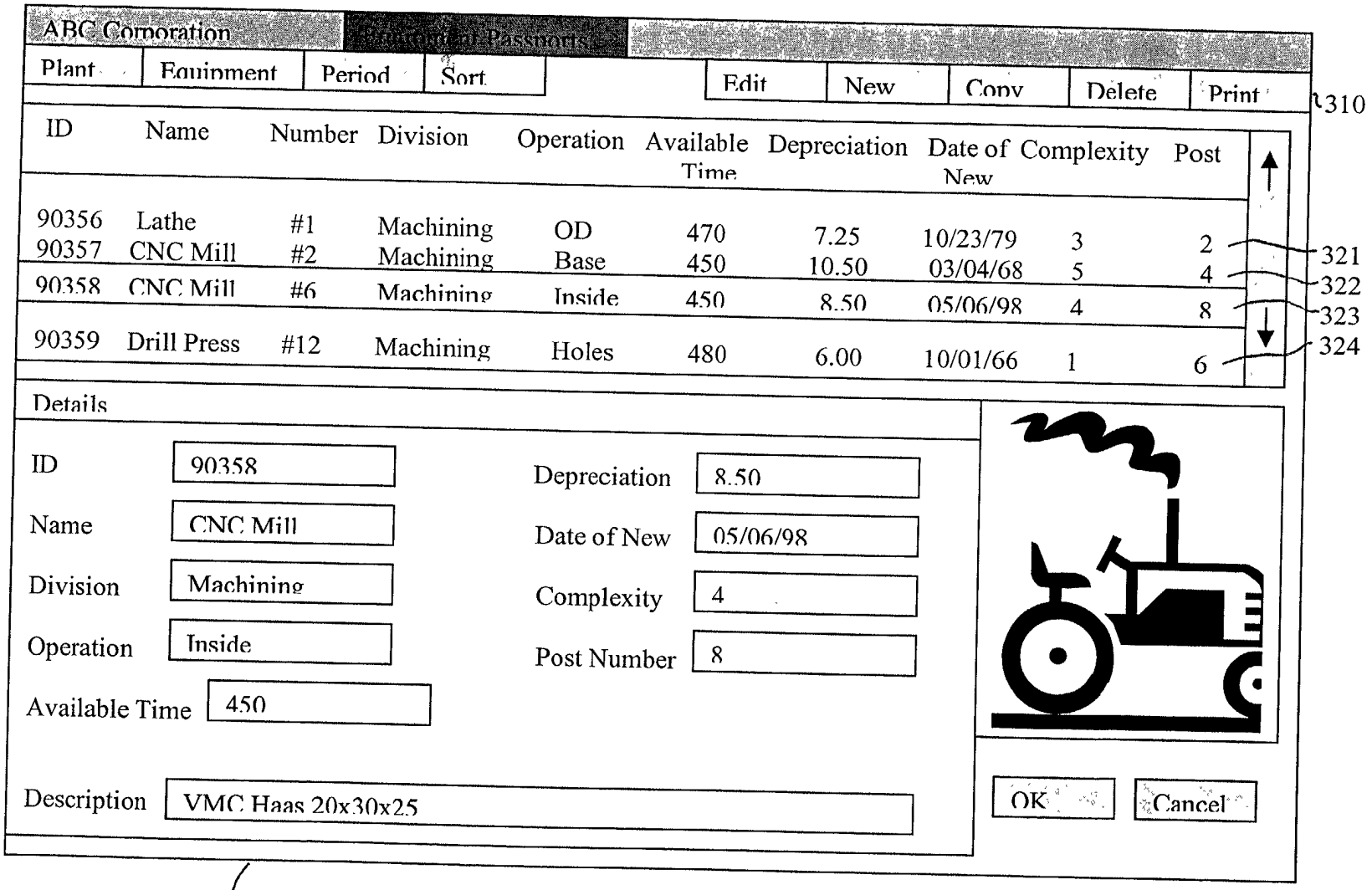

ABC Corporation
Plant
Equipment
Period
Sort
Edit
New
Conv
Delete
Print
310
ID
Name
Number
Division
Operation
Available Time
Depreciation
Date of New
Complexity
Post
90356 Lathe #1 Machining OD 470 7.25 10/23/79 3 2
90357 CNC Mill #2 Machining Base 450 10.50 03/04/68 5 4
90358 CNC Mill #6 Machining Inside 450 8.50 05/06/98 4 8
90359 Drill Press #12 Machining Holes 480 6.00 10/01/66 1 6
321
322
323
324
Details
ID 90358
Name CNC Mill
Division Machining
Operation Inside
Available Time 450
Depreciation 8.50
Date of New 05/06/98
Complexity 4
Post Number 8
Description VMC Haas 20x30x25
OK
Cancel
320

Fig. 9

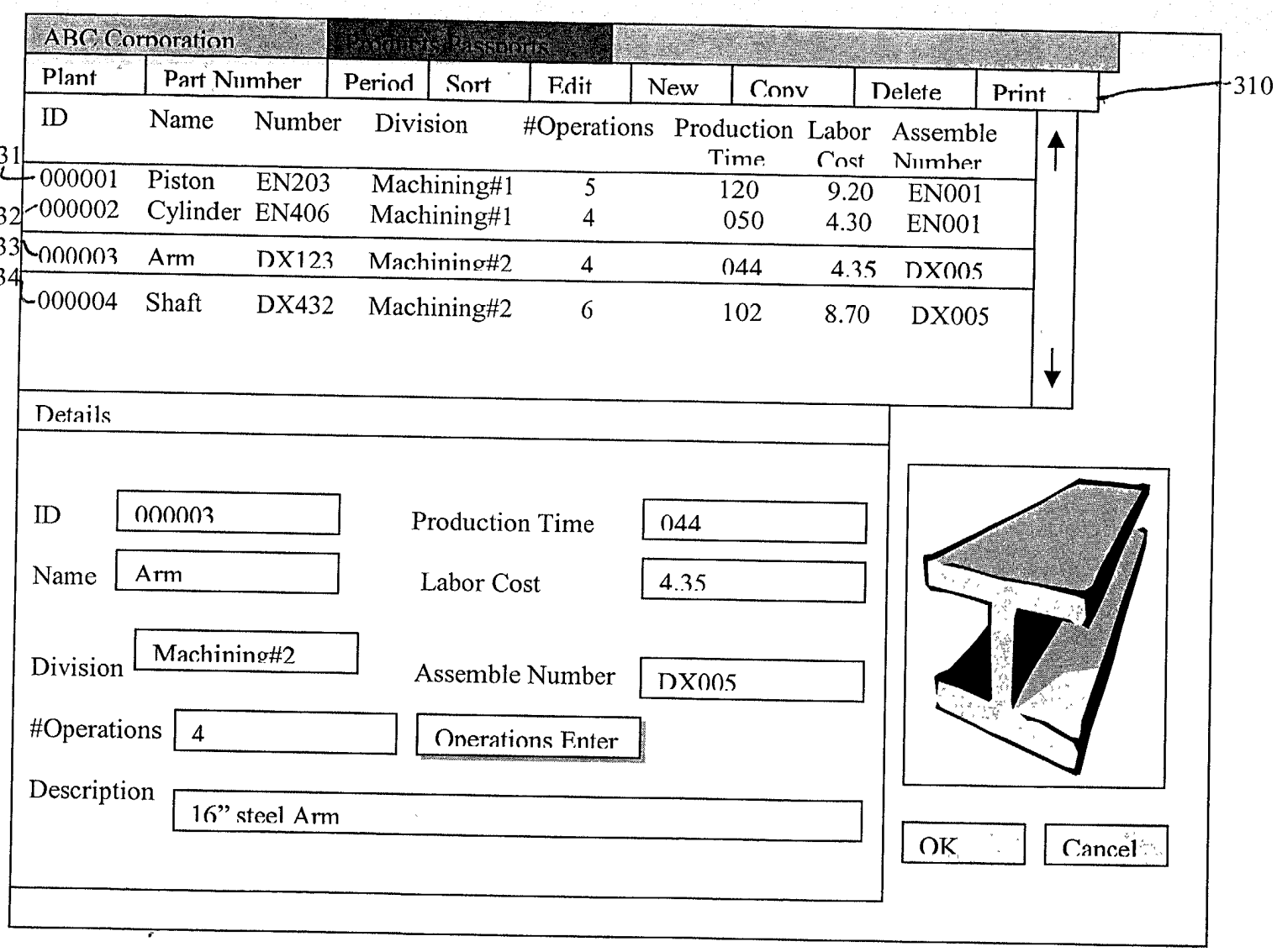

ABC Corporation
Products Passports
Plant
Part Number
Period
Sort
Edit
New
Conv
Delete
Print
310
ID
Name
Number
Division
#Operations
Production Time
Labor Cost
Assemble Number
331
000001 Piston EN203 Machining#1 5 120 9.20 EN001
332
000002 Cylinder EN406 Machining#1 4 050 4.30 EN001
333
000003 Arm DX123 Machining#2 4 044 4.35 DX005
334
000004 Shaft DX432 Machining#2 6 102 8.70 DX005
Details
ID 000003
Name Arm
Division Machining#2
#Operations 4
Operations Enter
Description 16" steel Arm
Production Time 044
Labor Cost 4.35
Assemble Number DX005
OK
Cancel
330

Fig. 10

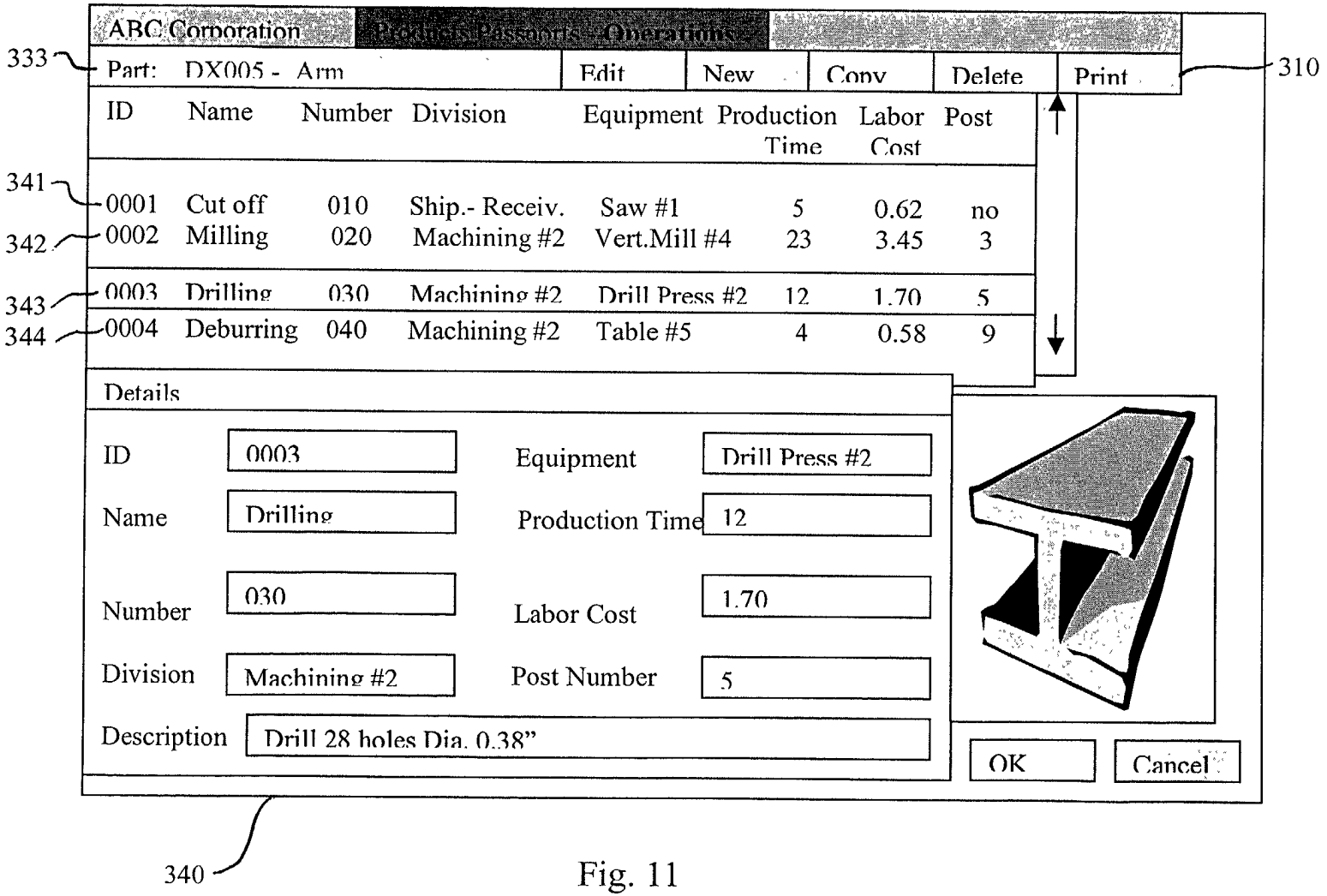

ABC Corporation
Products Passports Operations
333
Part: DX005 - Arm
Edit
New
Copy
Delete
Print
310
ID Name Number Division Equipment Production Time Labor Cost Post
341
0001 Cut off 010 Ship.- Receiv. Saw #1 5 0.62 no
342
0002 Milling 020 Machining #2 Vert.Mill #4 23 3.45 3
343
0003 Drilling 030 Machining #2 Drill Press #2 12 1.70 5
344
0004 Deburring 040 Machining #2 Table #5 4 0.58 9
Details
ID 0003
Name Drilling
Number 030
Division Machining #2
Description Drill 28 holes Dia. 0.38"
Equipment Drill Press #2
Production Time 12
Labor Cost 1.70
Post Number 5
OK
Cancel
340

Fig. 11

Table Format Schedule 350

ABC Enterprises Scheduling

351 FIRST SHIFT

	04/24/01		04/25/01		04/26/01		04/27/01		04/28/01		4/24-4/28	
	Monday		*Tuesday*		*Wednesday*		*Thursday*		*Friday*		*TOTAL PER WEEK*	
	Type	Quan.	Type	Quan.	Type	Quan.	Type	Quan.	Type	Quan.	Type	Quan.
361 Press Line	PR33	1250	PR33	1250	PR33	1250	PR33	1250	PR33	1250	PR33	6250
362 Weld Line	XE42	1250	XE42	1250	XE42	1250	XE42	1250	XE42	1250	XE42	6250
363 Trim Line	PL2	1250	PL2	1250	PL2	1250	PL2	1250	PL2	1250	PL2	6250
364 Paint Line	F6U3	1250	F6P2	1250	F2Y7	1250	R1B1	1250	B6W2	1250	B6W2	6250
365 Packaging Line	F6U3	1250	F6P2	1250	F2Y7	1250	R1B1	1250	B6W2	1250	B6W2	6250

352 SECOND SHIFT

	04/24/01		04/25/01		04/26/01		04/27/01		04/28/01		4/24-4/28	
	Monday		*Tuesday*		*Wednesday*		*Thursday*		*Friday*		*TOTAL PER WEEK*	
	Type	Quan.	Type	Quan.	Type	Quan.	Type	Quan.	Type	Quan.	Type	Quan.
361 Press Line	PR33	1250	PR33	1250	PR33	1250	PR33	1250	PR33	1250	PR33	6250
362 Weld Line	XE42	1250	XE42	1250	XE42	1250	XE42	1250	XE42	1250	XE42	6250
363 Trim Line	PL2	1250	PL2	1250	PL2	1250	PL2	1250	PL2	1250	PL2	6250
364 Paint Line	F6U3	1250	F6P2	1250	F2Y7	1250	R1B1	1250	B6W2	1250	B6W2	6250
365 Packaging Line	F6U3	1250	F6P2	1250	F2Y7	1250	R1B1	1250	B6W2	1250	B6W2	6250

Fig. 12

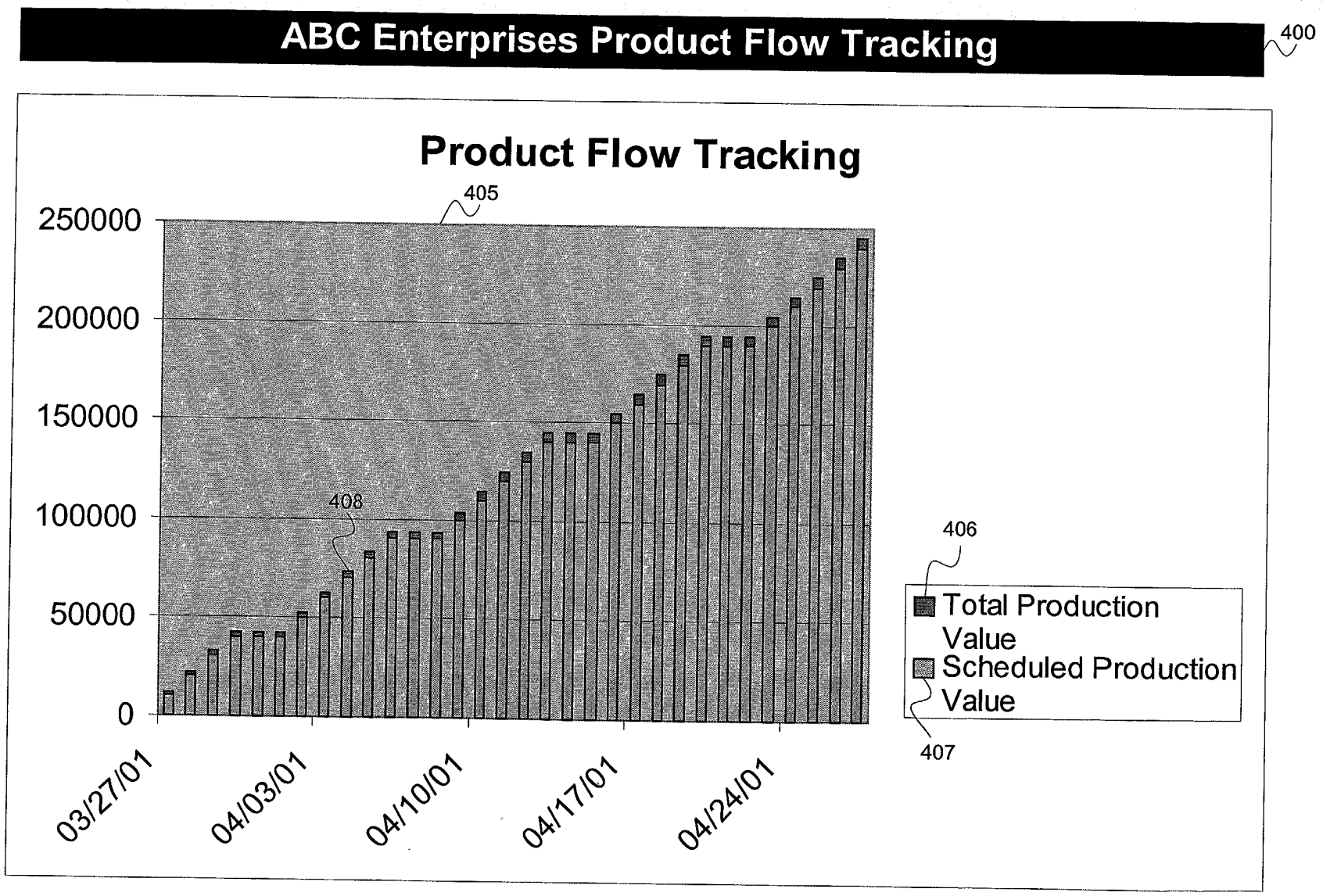

ABC Enterprises Product Flow Tracking
400
Product Flow Tracking
405
250000
200000
150000
100000
50000
0
408
406
Total Production Value
Scheduled Production Value
407
03/27/01
04/03/01
04/10/01
04/17/01
04/24/01

Fig. 13a

ABC Enterprises Product Flow Tracking

410

date	day	daily production value	total production value	scheduled production value	percent manufactured
03/27/01	tue	8500	8500	10000	85%
03/28/01	wed	10000	18500	20000	93%
03/29/01	thur	9100	27600	30000	92%
03/30/01	fri	10000	37600	40000	94%
03/31/01	sat	0	37600	40000	94%
04/01/01	sun	0	37600	40000	94%
04/02/01	mon	10000	47600	50000	95%
04/03/01	tue	10000	57600	60000	96%
04/04/01	wed	9000	66600	70000	95%
04/05/01	thur	10000	76600	80000	96%
04/06/01	fri	10000	86600	90000	96%
04/07/01	sat	0	86600	90000	96%
04/08/01	sun	0	86600	90000	96%
04/09/01	mon	10000	96600	100000	97%
04/10/01	tue	9100	105700	110000	96%
04/11/01	wed	10000	115700	120000	96%
04/12/01	thur	9510	125210	130000	96%
04/13/01	fri	10000	135210	140000	97%
04/14/01	sat	0	135210	140000	97%
04/15/01	sun	0	135210	140000	97%
04/16/01	mon	10000	145210	150000	97%
04/17/01	tue	10000	155210	160000	97%
04/18/01	wed	9800	165010	170000	97%
04/19/01	thur	10000	175010	180000	97%
04/20/01	fri	10000	185010	190000	97%
04/21/01	sat	0	185010	190000	97%
04/22/01	sun	0	185010	190000	97%
04/23/01	mon	10000	195010	200000	98%
04/24/01	tue	9850	204860	210000	98%
04/25/01	wed	9853	214713	220000	98%
04/26/01	thur	10000	224713	230000	98%
04/27/01	fri	10000	234713	240000	98%

412

414 415 416 417 418

Fig. 13b

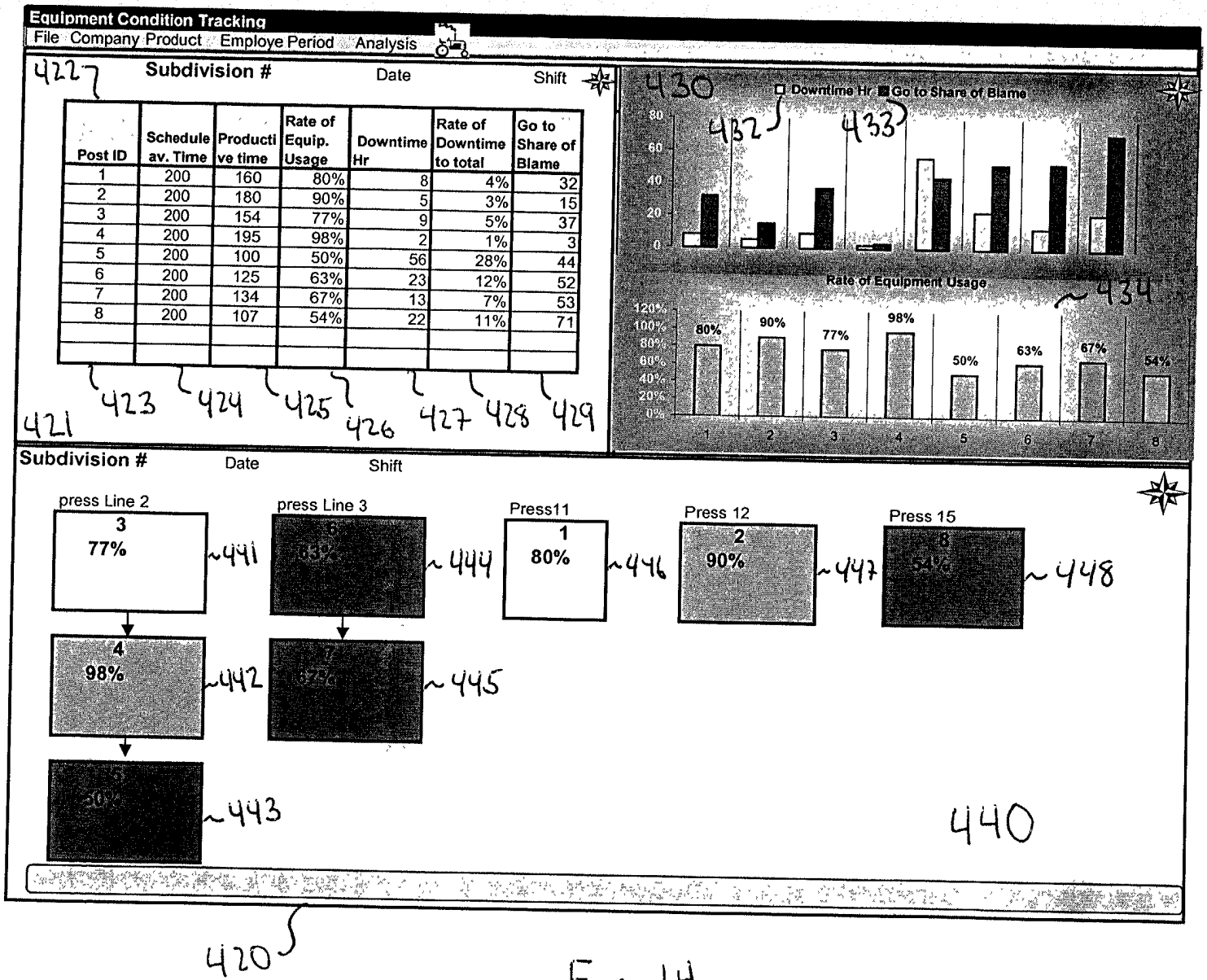

Equipment Condition Tracking
File Company Product Employe Period Analysis
427
Subdivision #
Date
Shift
Post ID | Schedule av. Time | Productive time | Rate of Equip. Usage | Downtime Hr | Rate of Downtime to total | Go to Share of Blame
1 | 200 | 160 | 80% | 8 | 4% | 32
2 | 200 | 180 | 90% | 5 | 3% | 15
3 | 200 | 154 | 77% | 9 | 5% | 37
4 | 200 | 195 | 98% | 2 | 1% | 3
5 | 200 | 100 | 50% | 56 | 28% | 44
6 | 200 | 125 | 63% | 23 | 12% | 52
7 | 200 | 134 | 67% | 13 | 7% | 53
8 | 200 | 107 | 54% | 22 | 11% | 71
423
424
425
426
427
428
429
421
430
Downtime Hr
Go to Share of Blame
432
433
Rate of Equipment Usage
434
80%
90%
77%
98%
50%
63%
67%
54%
Subdivision #
Date
Shift
press Line 2
3
77%
441
press Line 3
6
63%
444
Press11
1
80%
446
Press 12
2
90%
447
Press 15
8
54%
448
4
98%
442
7
67%
445
5
50%
443
440
420

Fig. 14

450

ABC Enterprises Manufacturing Efficiency and Costing

File Company View Product Employees Period Analysis

Subdivision	Scheduled efficiency	Actual efficiency	Percent efficiency
Press Line	.21 man hour / part	.27 man hour / part	-29%
Weld Line	.25 man hour / part	.32 man hour / part	-28%
Trim Line	.25 man hour / part	.22 man hour / part	12%
Paint Line	.15 man hour / part	.19 man hour / part	-26%
Assembly Line	.30 man hour / part	.28 man hour / part	7%
Package Line	.20 man hour / part	.18 man hour / part	10%

451 452 453 454 455

Fig. 15a

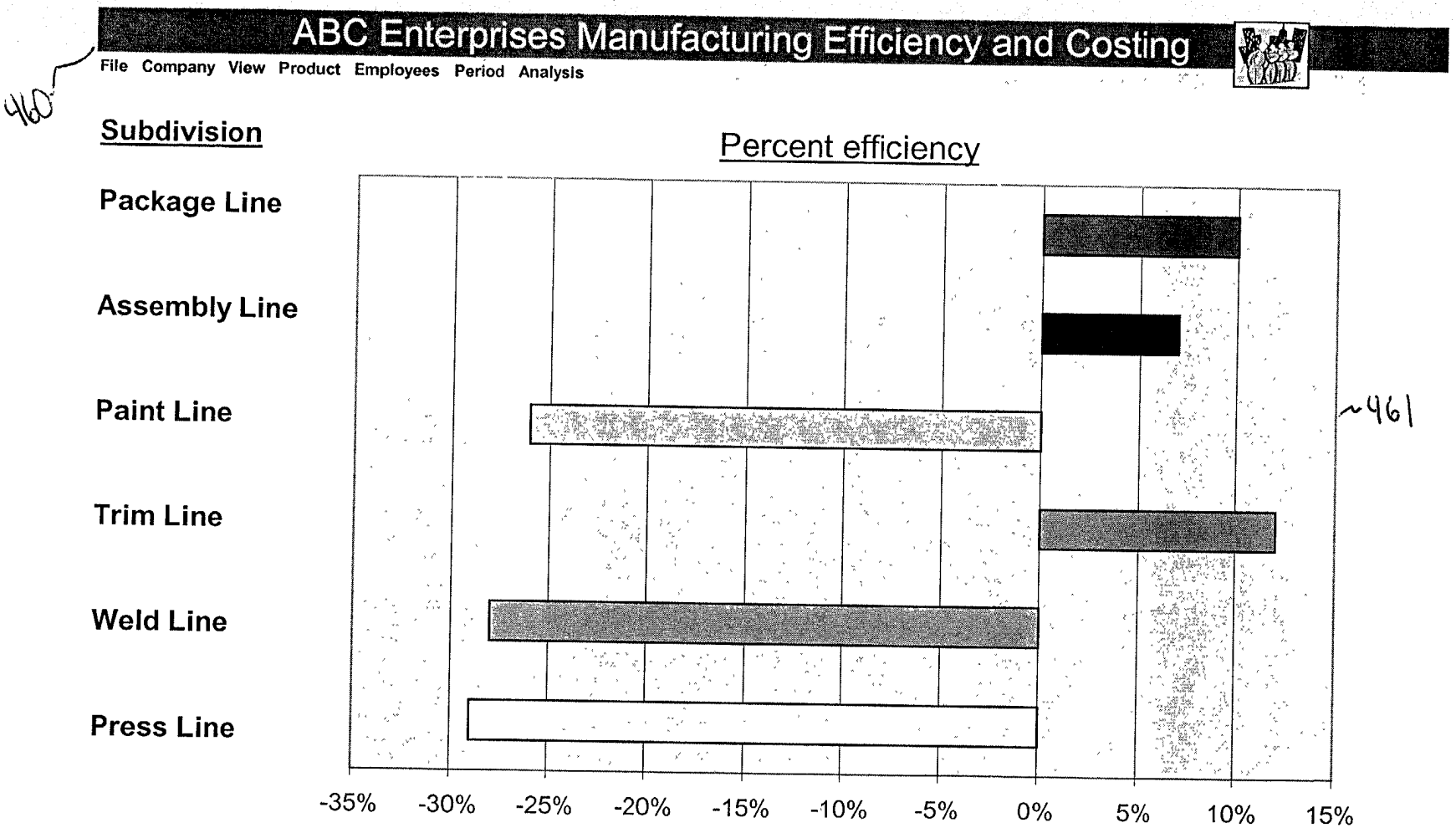

ABC Enterprises Manufacturing Efficiency and Costing
File Company View Product Employees Period Analysis
960
Subdivision
Percent efficiency
Package Line
Assembly Line
Paint Line
Trim Line
Weld Line
Press Line
961
-35%
-30%
-25%
-20%
-15%
-10%
-5%
0%
5%
10%
15%

Fig. 15b

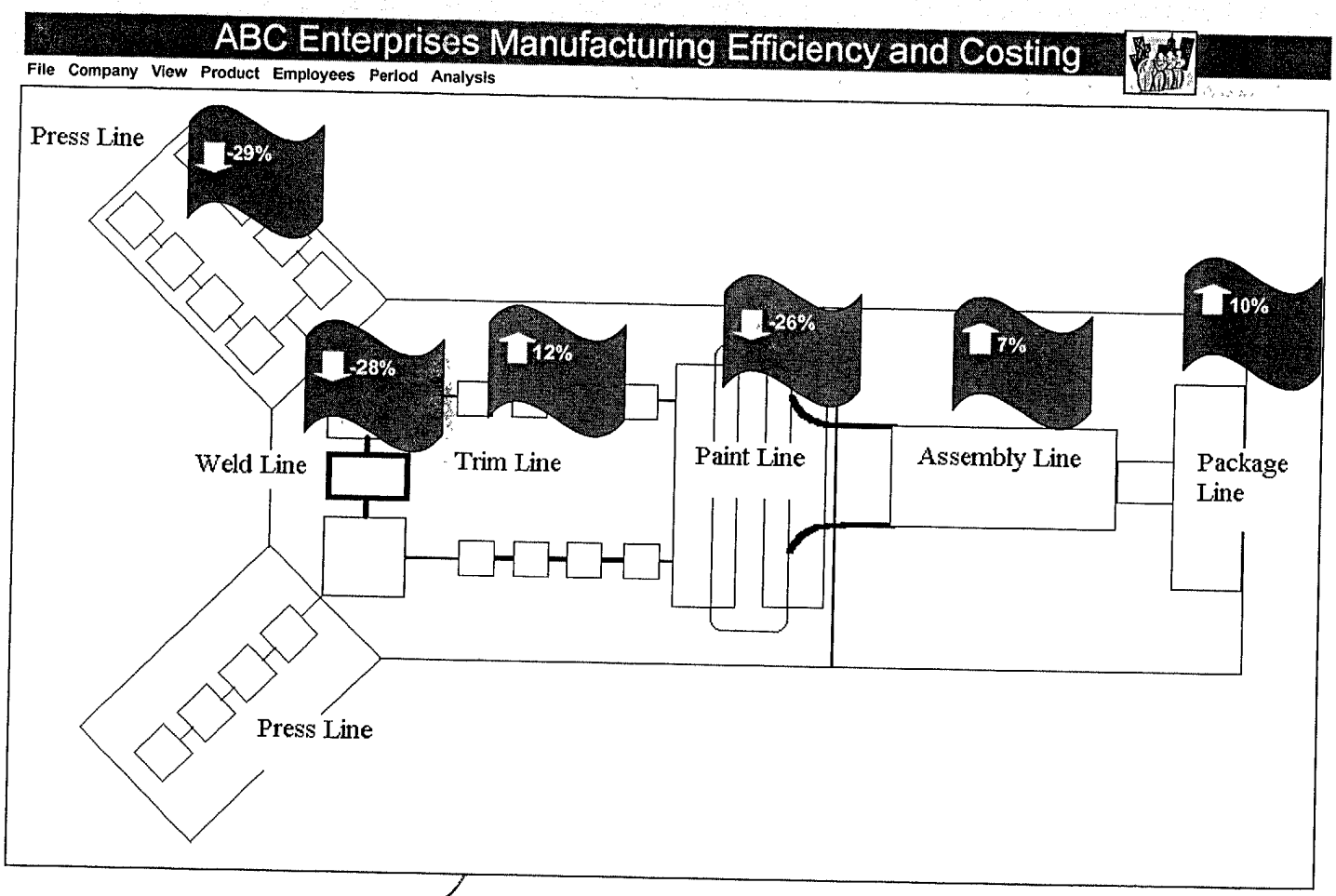

ABC Enterprises Manufacturing Efficiency and Costing
File Company View Product Employees Period Analysis
Press Line
-29%
-28%
12%
-26%
7%
10%
Weld Line
Trim Line
Paint Line
Assembly Line
Package Line
Press Line
470

Fig. 15c

Employees Utilization and Performance Tracking

File Company Product Employee Period Analysis

Subdivision # Date Shift

Employee	Post #	Total Time	Active time	Inactive time	Efficiency
John	101	5:36	4:46	0:50	79%
Mary	102	5:34	5:04	0:30	97%
Kathy	103	5:05	3:25	1:40	95%
Jack	104	5:51	5:35	0:16	101%
Sally	105	2:55	2:40	0:15	105%
Bob	106	6:07	5:17	0:50	76%
Jim	110	5:29	4:48	0:41	82%
Ali-Baba	111	5:44	5:32	0:12	104%
Tom	112	5:36	4:46	0:50	79%
Bo	113	5:34	5:04	0:30	97%
Kit	114	5:05	3:26	1:39	95%
Ron	115	5:51	5:36	0:15	101%
Nick	116	2:55	2:40	0:15	105%
Alex	120	6:07	5:17	0:50	76%
Jay	121	5:29	4:48	0:41	82%
Stive	122	5:44	5:32	0:12	104%
Joe	123	5:29	4:48	0:41	82%
Baba	124	5:44	5:32	0:12	104%
Bill	125	5:36	4:46	0:50	79%
Boss	126	5:34	5:04	0:30	97%
Tim	127	5:05	3:26	1:39	95%

480 481 482 483 484 485 486 487

Fig. 16a

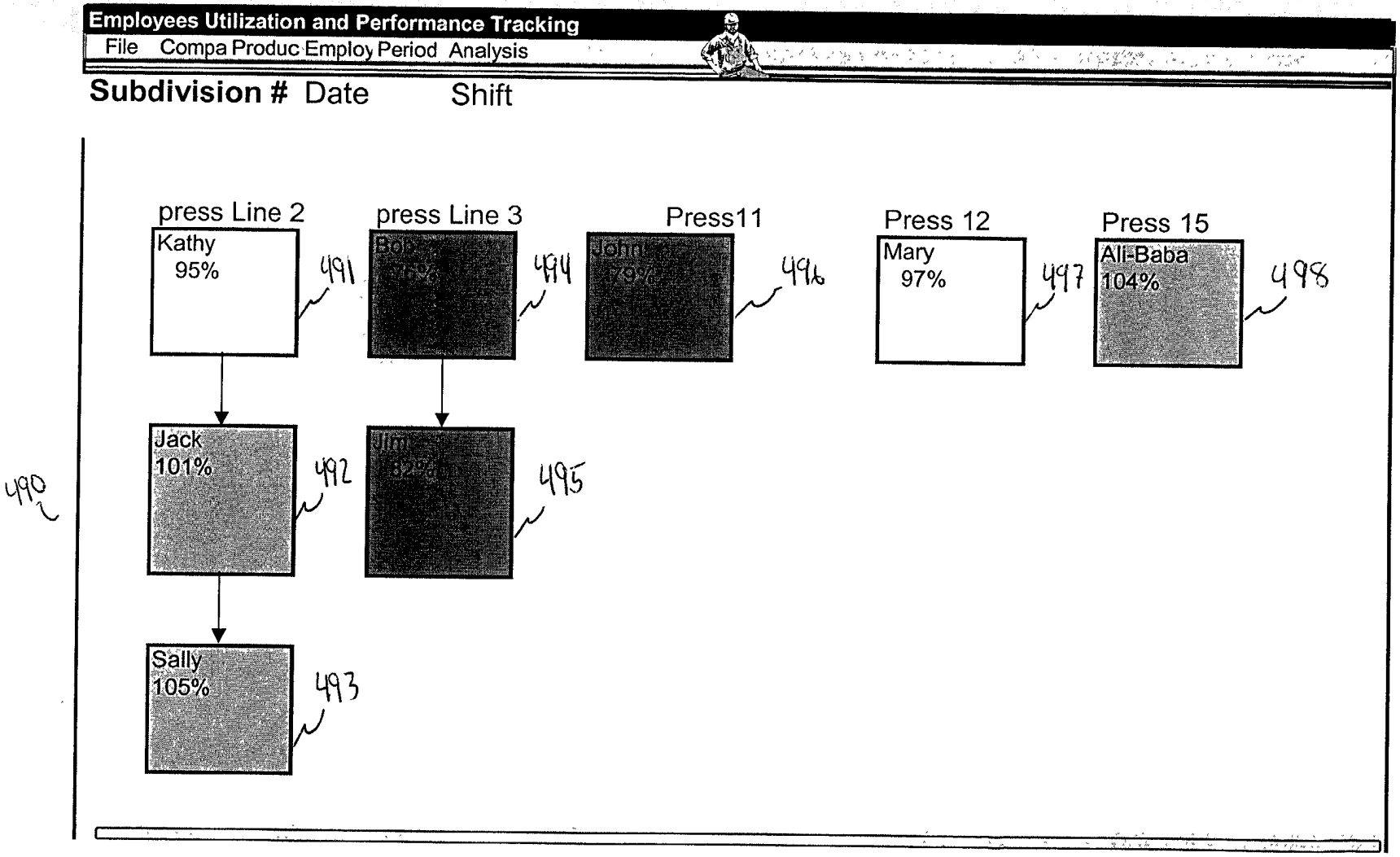

Employees Utilization and Performance Tracking
File Compa Produc Employ Period Analysis
Subdivision # Date Shift
press Line 2
press Line 3
Press11
Press 12
Press 15
Kathy
95%
Bob
Johnl
Mary
97%
Ali-Baba
104%
Jack
101%
Jim
Sally
105%
490
491
492
493
494
495
496
497
498

Fig. 16b

Employees Utilization and Performance Tracking

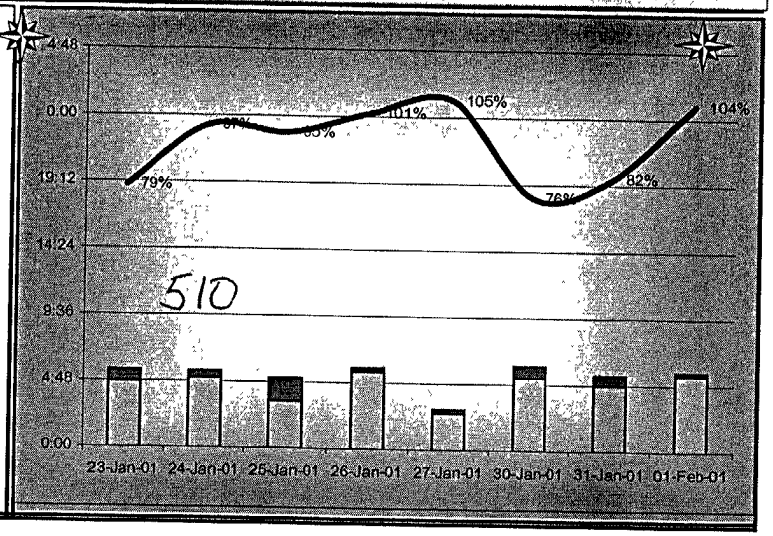
File Company Product Employee Period Analysis

501

Employee **Mary** Period 01/23/01 - 02/04/01

DATE	Post	Total Time	Active time	Inactive time	Efficiency
23-Jan-01	101	5:36	4:46	0:50	79%
24-Jan-01	102	5:34	5:03	0:30	97%
25-Jan-01	103	5:05	3:25	1:39	95%
26-Jan-01	103	5:51	5:35	0:15	101%
27-Jan-01	103	2:55	2:39	0:15	105%
30-Jan-01	105	6:07	5:16	0.50	76%
31-Jan-01	105	5:29	4:48	0:41	82%
01-Feb-01	107	5:44	5:31	0:12	104%
02-Feb-01	102				
03-Feb-01	102				
04-Feb-01	102				

502 503 504 505 506 507



Employee Mary Lee

ID	56787	Pay Rate	25.65
Name	Mary Lee	Date of hire	10/10/1998
Division	Forming	Siniority	3
Position	Operator		
Description	Needs Close Supervision		

500

515

Average Efficiency 92%

Fig. 16c

Employees Utilization and Performance Tracking

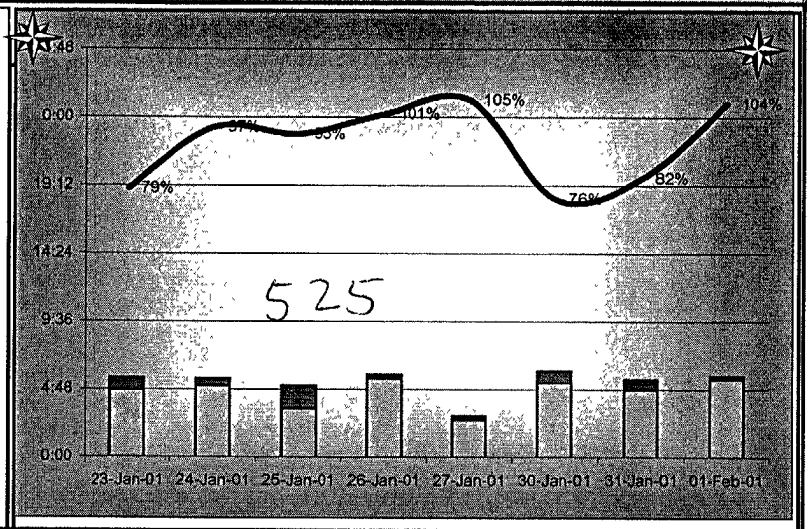
File Company Product Employee Period Analysis

Post 101 Period 01/23/01 - 02/04/01

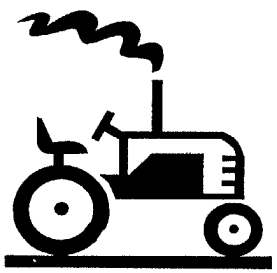
DATE	Employee	Total Time	Active time	Inactive time	Efficiency
23-Jan-01	John	5:36	4:46	0:50	79%
24-Jan-01	Mary	5:34	5:04	0:30	97%
25-Jan-01	Kathy	5:05	3:26	1:39	95%
26-Jan-01	Jack	5:51	5:36	0:15	101%
27-Jan-01	Sally	2:55	2:40	0:15	105%
30-Jan-01	Bob	6:07	5:17	0:50	76%
31-Jan-01	Jim	5:29	4:48	0:41	82%
01-Feb-01	Ali-Baba	5:44	5:32	0:12	104%
02-Feb-01					
03-Feb-01					
04-Feb-01					

522

521



F 101



520

ID 23456

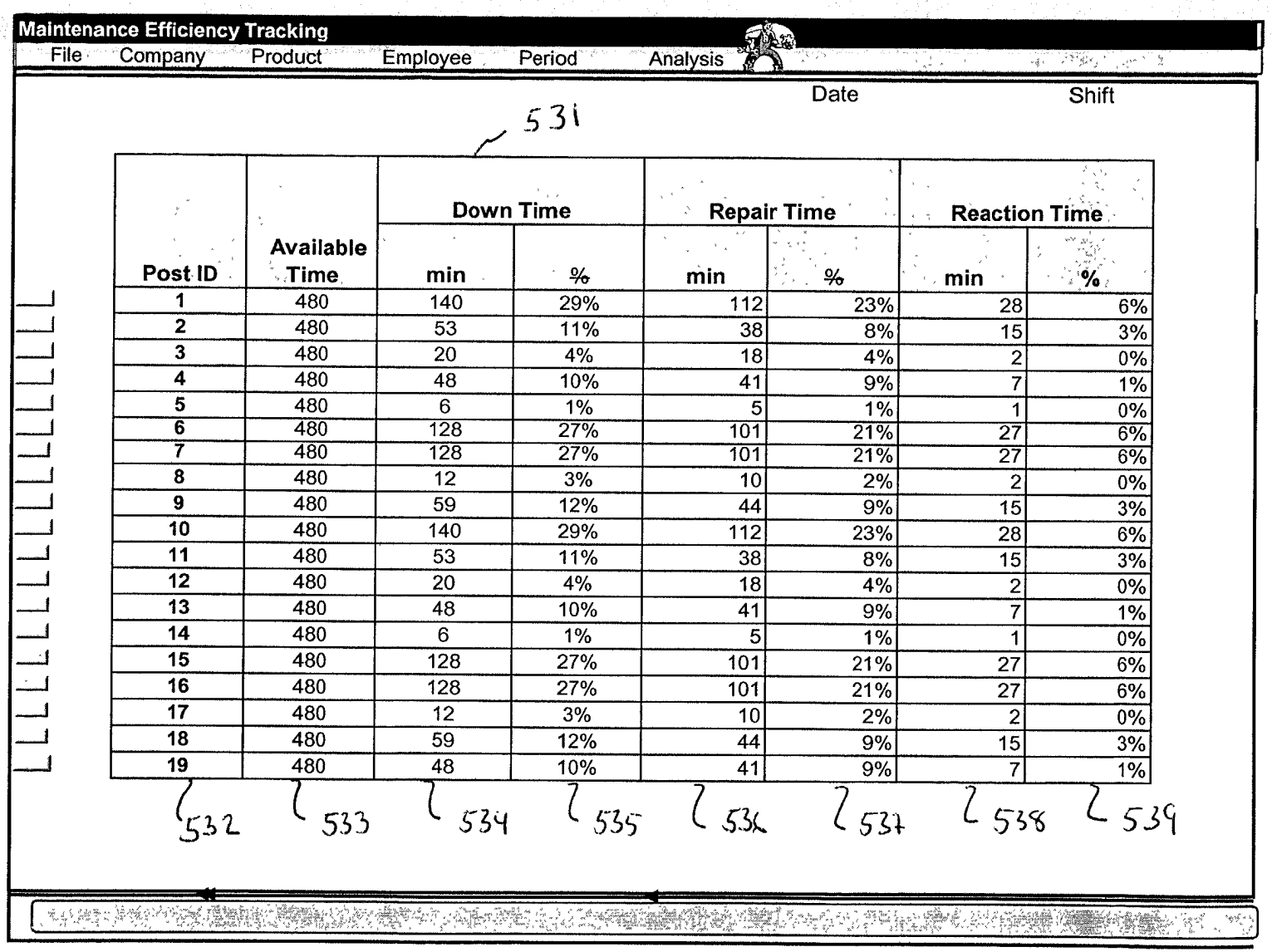
Name Press

Description 200 ton mechanical press

Average Efficiency 92%

527

Fig. 16d



Post ID	Available Time	Down Time		Repair Time		Reaction Time	
		min	%	min	%	min	%
1	480	140	29%	112	23%	28	6%
2	480	53	11%	38	8%	15	3%
3	480	20	4%	18	4%	2	0%
4	480	48	10%	41	9%	7	1%
5	480	6	1%	5	1%	1	0%
6	480	128	27%	101	21%	27	6%
7	480	128	27%	101	21%	27	6%
8	480	12	3%	10	2%	2	0%
9	480	59	12%	44	9%	15	3%
10	480	140	29%	112	23%	28	6%
11	480	53	11%	38	8%	15	3%
12	480	20	4%	18	4%	2	0%
13	480	48	10%	41	9%	7	1%
14	480	6	1%	5	1%	1	0%
15	480	128	27%	101	21%	27	6%
16	480	128	27%	101	21%	27	6%
17	480	12	3%	10	2%	2	0%
18	480	59	12%	44	9%	15	3%
19	480	48	10%	41	9%	7	1%

Fig 17a

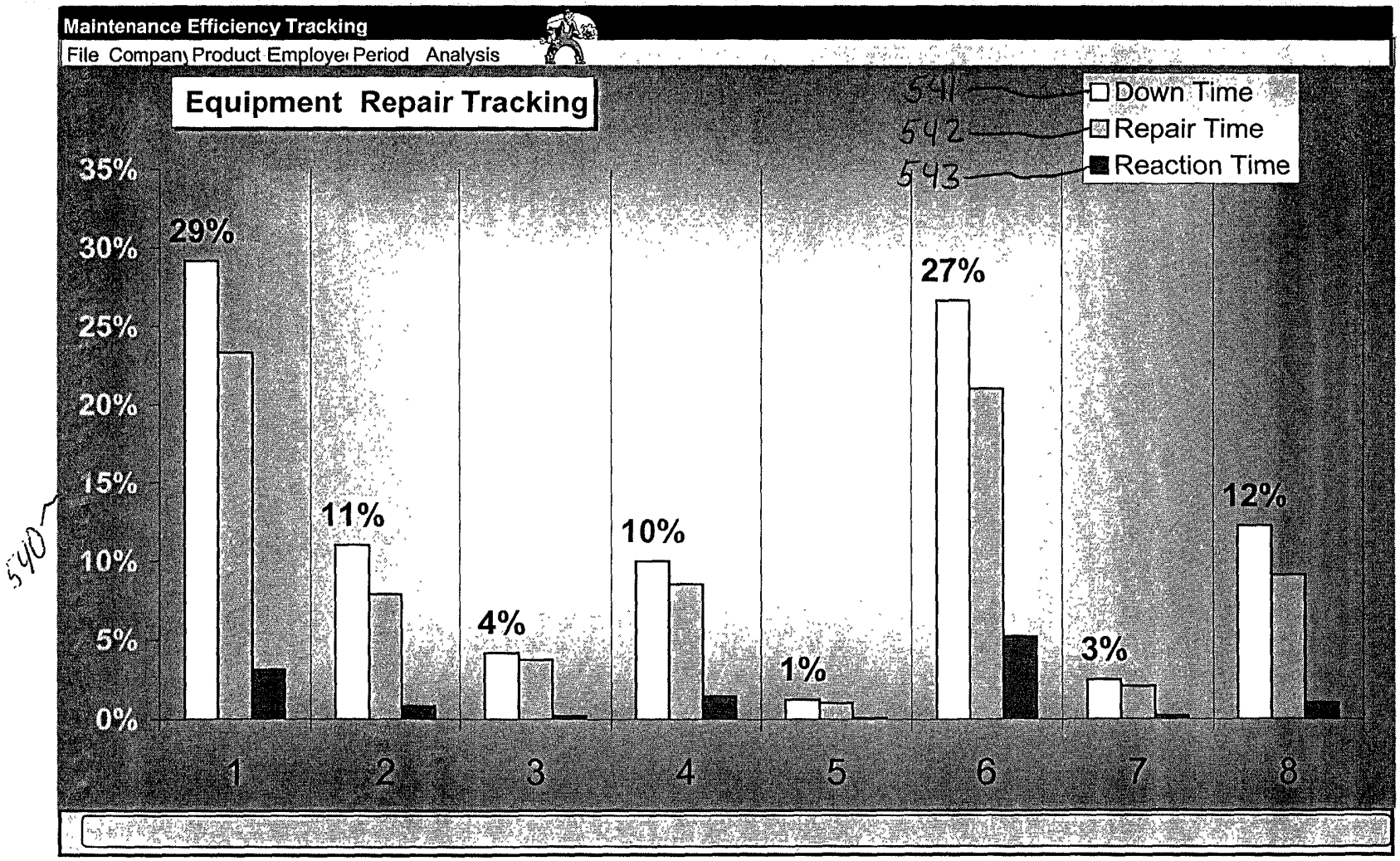


Fig. 17b

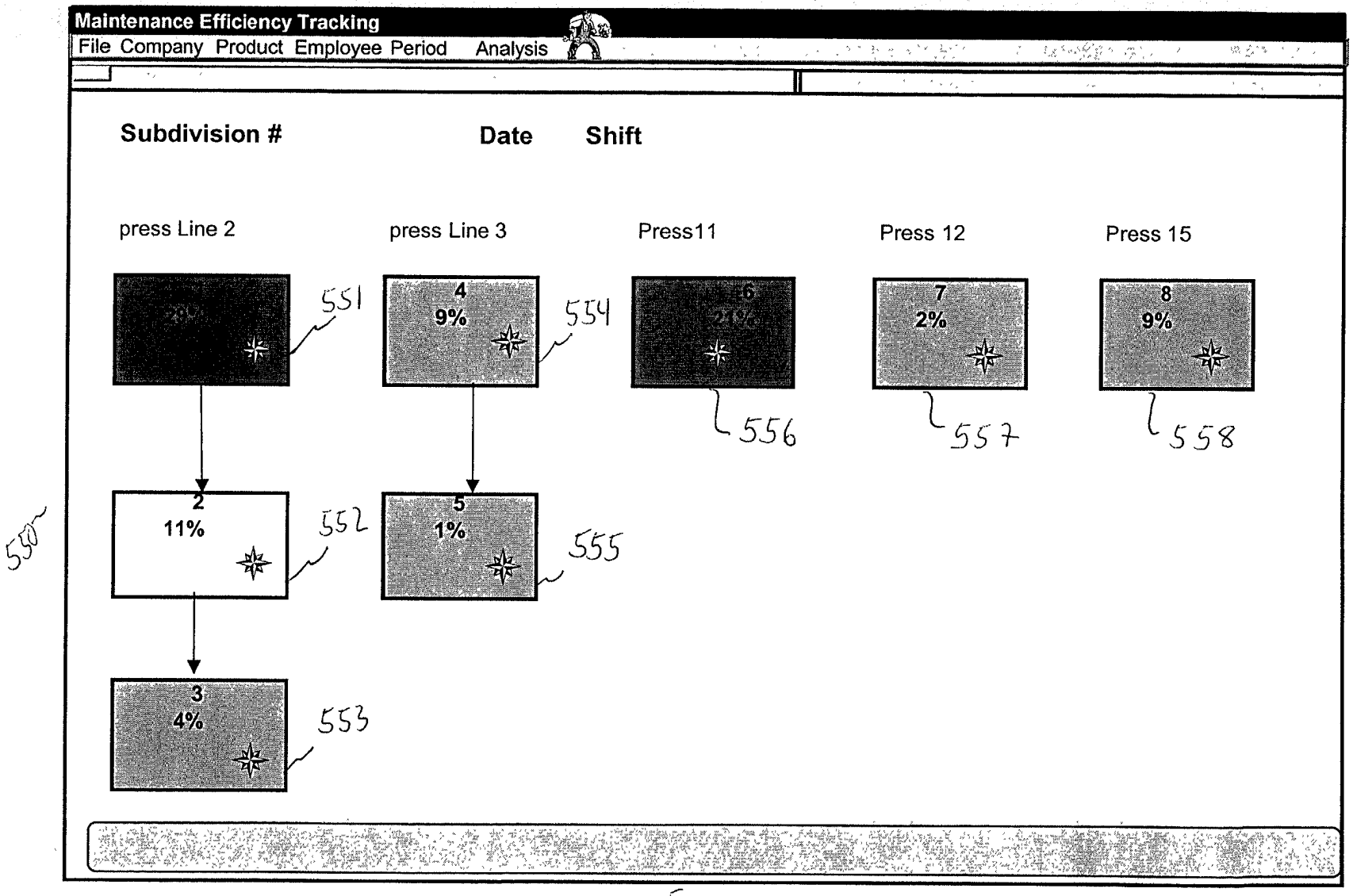

Maintenance Efficiency Tracking
File Company Product Employee Period Analysis
Subdivision #
Date
Shift
press Line 2
press Line 3
Press11
Press 12
Press 15
4
9%
7
2%
8
9%
2
11%
5
1%
3
4%
551
554
556
557
558
552
555
553
550

Fig 17c

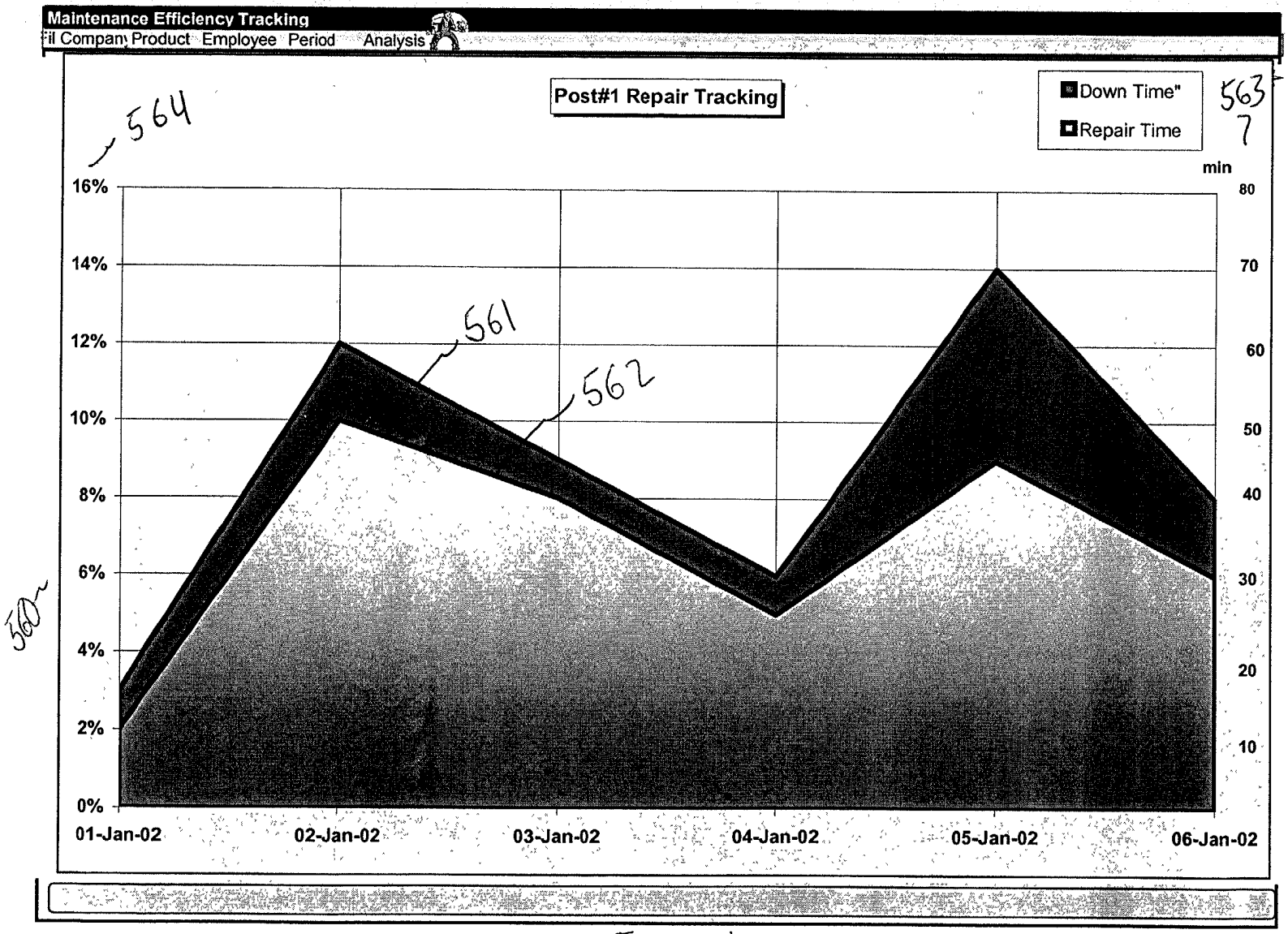

Maintenance Efficiency Tracking
Fil Company Product Employee Period Analysis
Post#1 Repair Tracking
Down Time"
Repair Time
563
564
561
562
560
min
16%
14%
12%
10%
8%
6%
4%
2%
0%
80
70
60
50
40
30
20
10
01-Jan-02
02-Jan-02
03-Jan-02
04-Jan-02
05-Jan-02
06-Jan-02

Fig. 17d

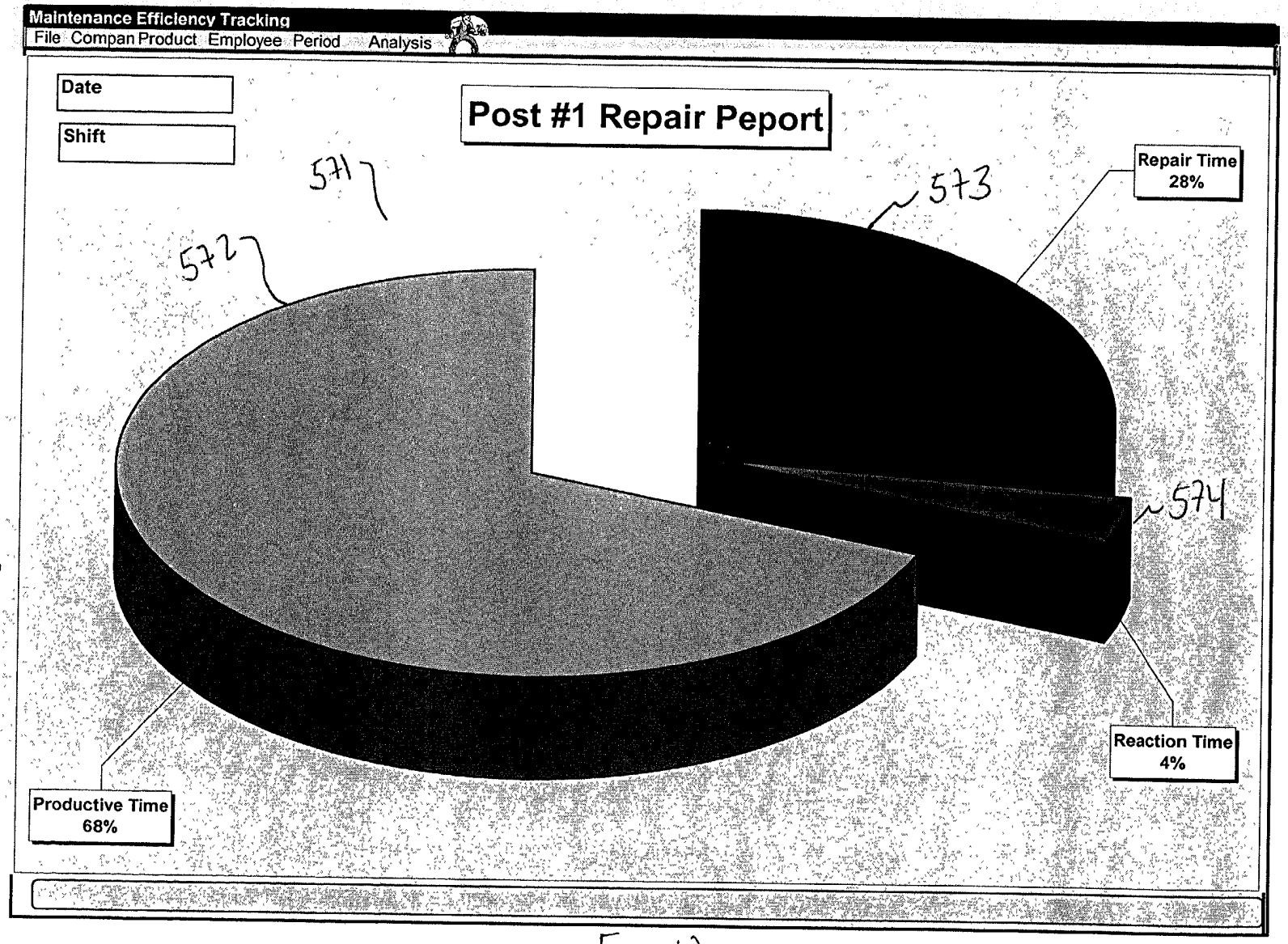

Maintenance Efficiency Tracking
File Compan Product Employee Period Analysis
Date
Shift
Post #1 Repair Peport
571
572
573
574
570
Repair Time
28%
Reaction Time
4%
Productive Time
68%

Fig. 17c

Share of Blame

File Company Product Employee Period Analysis

Subdivision # Date Shift

Post ID	Schedule av. Time	PT Production Run Time	Downtime					Set up time			PMT PM Time	DT Dead Time	Technician	
			DOT No Operator	DMT No Material	DET Machine Failure	DTT Tool Failure	DQT QC Problem	DUT Undefined	STT Tool/ Machine	SMT Material			TID Technician ID	TRT
1	200	180	35%	10%	14%	19%	0%	0%	5%	6%	0%	11%		
2	200	165	0%	0%	72%	0%	14%	0%	5%	8%	0%	1%		
3	200	100	1%	21%	0%	0%	0%	0%	12%	9%	0%	57%		
4	200	196	12%	0%	75%	0%	0%	0%	0%	12%	0%	1%		
5	200	125	15%	10%	0%	36%	17%	0%	0%	4%	0%	18%		
6	200	177	3%	25%	14%	0%	0%	45%	0%	5%	5%	3%		
7	200	180	35%	10%	14%	19%	0%	0%	5%	6%	0%	11%		
8	200	165	0%	0%	72%	0%	14%	0%	5%	8%	0%	1%		
9	200	100	1%	21%	0%	0%	0%	0%	12%	9%	0%	57%		
10	200	196	12%	0%	75%	0%	0%	0%	0%	12%	0%	1%		
11	200	125	15%	10%	0%	36%	17%	0%	0%	4%	0%	18%		
12	200	177	3%	25%	14%	0%	0%	45%	0%	5%	5%	3%		
13	200	180	35%	10%	14%	19%	0%	0%	5%	6%	0%	11%		
14	200	165	0%	0%	72%	0%	14%	0%	5%	8%	0%	1%		
15	200	100	1%	21%	0%	0%	0%	0%	12%	9%	0%	57%		
16	200	196	12%	0%	75%	0%	0%	0%	0%	12%	0%	1%		
17	200	125	15%	10%	0%	36%	17%	0%	0%	4%	0%	18%		
18	200	177	3%	25%	14%	0%	0%	45%	0%	5%	5%	3%		
19	200	180	35%	10%	14%	19%	0%	0%	5%	6%	0%	11%		
20	200	165	0%	0%	72%	0%	14%	0%	5%	8%	0%	1%		
21	200	100	1%	21%	0%	0%	0%	0%	12%	9%	0%	57%		
22	200	196	12%	0%	75%	0%	0%	0%	0%	12%	0%	1%		
23	200	125	15%	10%	0%	36%	17%	0%	0%	4%	0%	18%		
24	200	177	3%	25%	14%	0%	0%	45%	0%	5%	5%	3%		
25	200	180	35%	10%	14%	19%	0%	0%	5%	6%	0%	11%		
26	200	165	0%	0%	72%	0%	14%	0%	5%	8%	0%	1%		
27	200	100	1%	21%	0%	0%	0%	0%	12%	9%	0%	57%		
28	200	196	12%	0%	75%	0%	0%	0%	0%	12%	0%	1%		
29	200	125	15%	10%	0%	36%	17%	0%	0%	4%	0%	18%		
30	200	177	3%	25%	14%	0%	0%	45%	0%	5%	5%	3%		

580

581 582 583 584 585 586 587 588 589 590 591 592 593

Fig. 18a

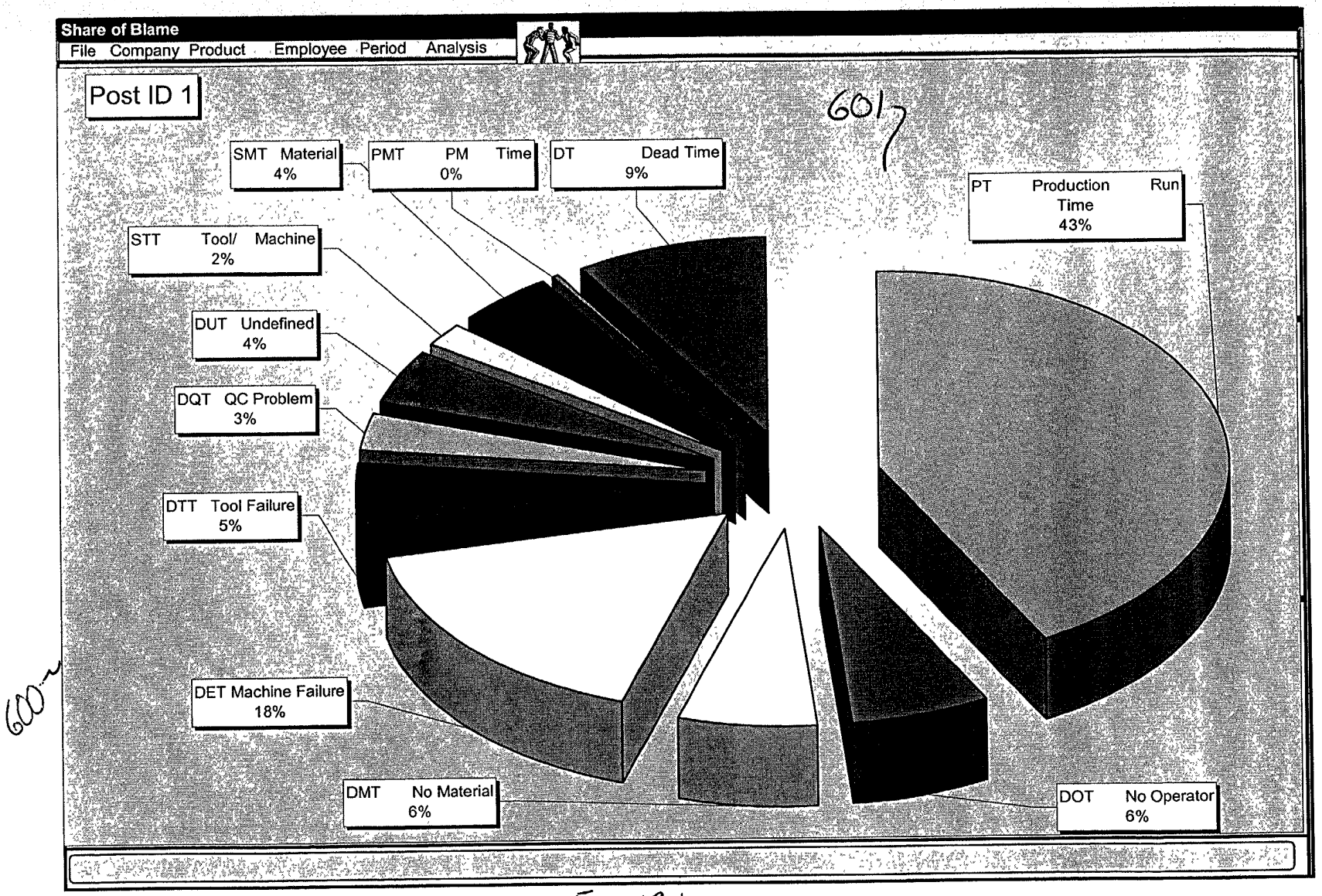

Share of Blame
File Company Product Employee Period Analysis
Post ID 1
601
600
SMT Material 4%
PMT PM Time 0%
DT Dead Time 9%
PT Production Run Time 43%
STT Tool/ Machine 2%
DUT Undefined 4%
DQT QC Problem 3%
DTT Tool Failure 5%
DET Machine Failure 18%
DMT No Material 6%
DOT No Operator 6%

Fig. 18b

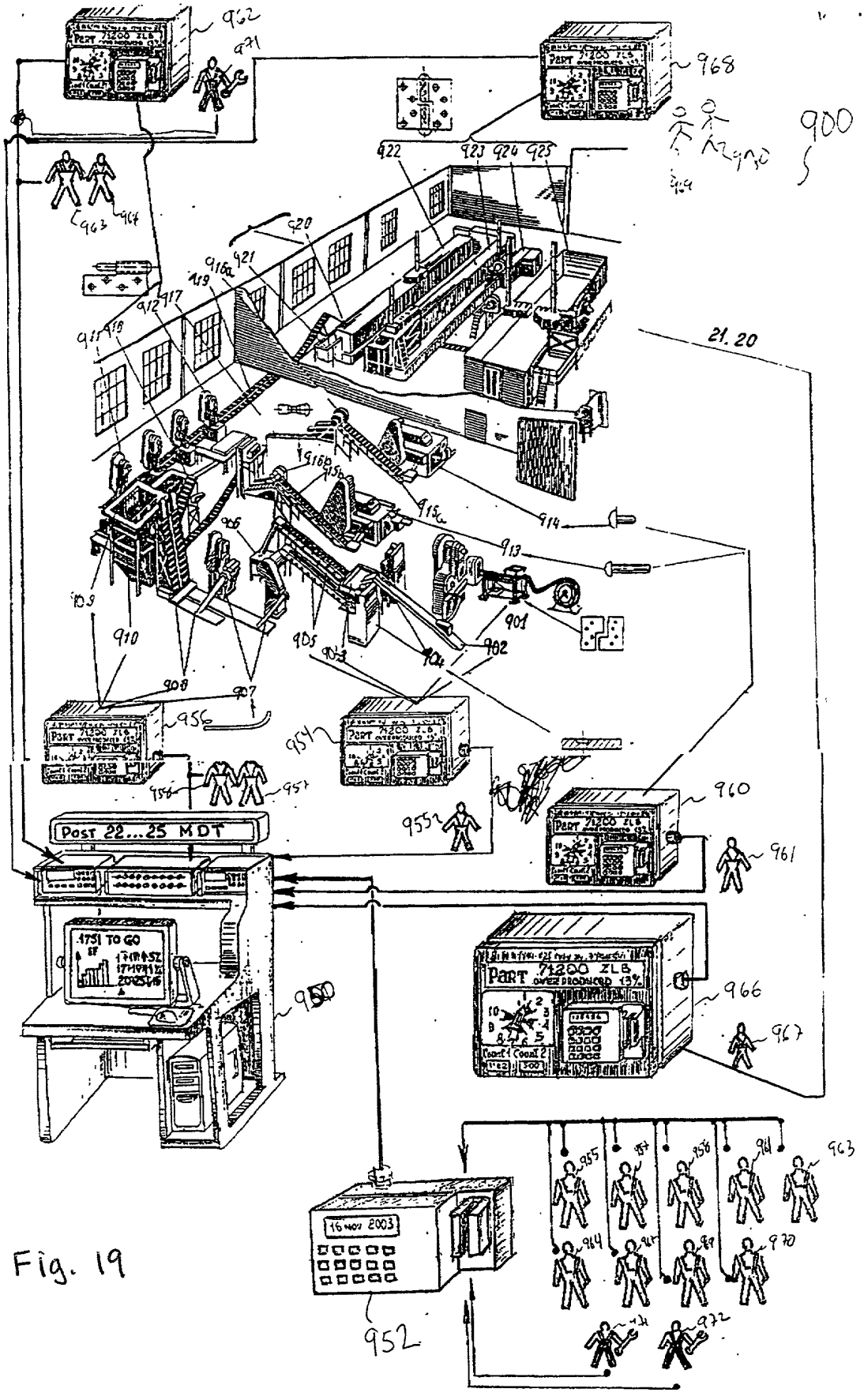

962
971
968
900
963
964
922
923
924
925
920
916a
921
919
917
912
918
911
21.20
916b
915
915a
914
913
909
906
910
905
903
904
902
901
908
907
956
954
957
955
960
961
Post 22...25 MDT
1731 TO GO
950
Part 71200 ZLB
966
967
16 NOV 2003
952
963
955
956
964
970
972
974

Fig. 19

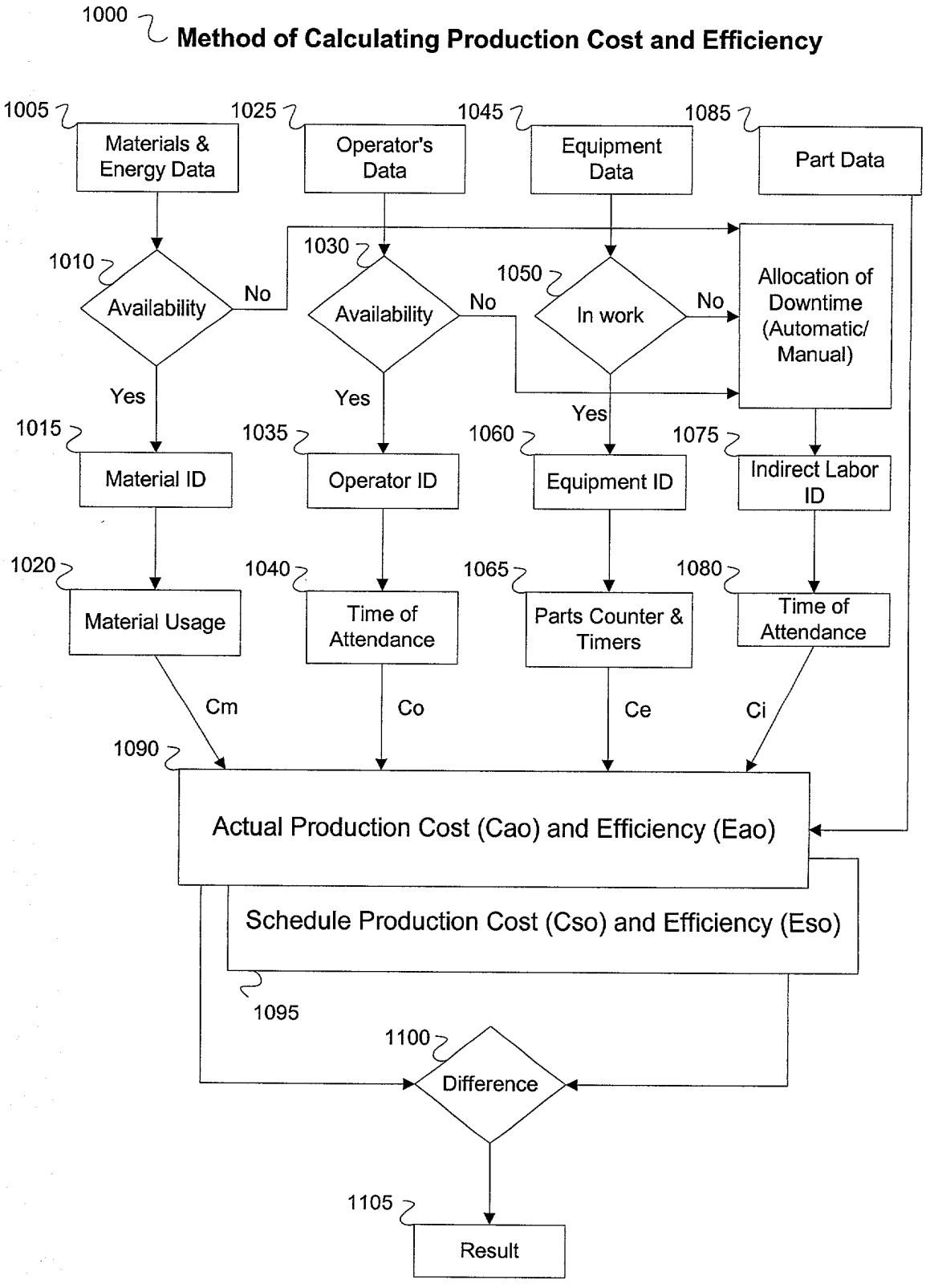

1000
Method of Calculating Production Cost and Efficiency
1005
Materials & Energy Data
1025
Operator's Data
1045
Equipment Data
1085
Part Data
1010
Availability
No
1030
Availability
No
1050
In work
No
Allocation of Downtime (Automatic/ Manual)
Yes
Yes
Yes
1015
Material ID
1035
Operator ID
1060
Equipment ID
1075
Indirect Labor ID
1020
Material Usage
1040
Time of Attendance
1065
Parts Counter & Timers
1080
Time of Attendance
Cm
Co
Ce
Ci
1090
Actual Production Cost (Cao) and Efficiency (Eao)
Schedule Production Cost (Cso) and Efficiency (Eso)
1095
1100
Difference
1105
Result

Fig. 20